

FAA-RD-77-115

NASA CR-135213  
PWA-5534

(NASA-CR-135213) EVALUATION OF FEDERAL  
AVIATION ADMINISTRATION ENGINE EXHAUST  
SAMPLING RAKE Final Report (Pratt and  
Whitney Aircraft Group) 61 p HC A04/MP A01

N73-21111

Unclas  
CSCL 21F 63/07 14006

## EVALUATION OF FEDERAL AVIATION ADMINISTRATION ENGINE EXHAUST SAMPLING RAKE



A. J. Fiorentino, W. Greene, and R. Roberts  
United Technologies Corporation  
Pratt & Whitney Aircraft Group  
Commercial Products Division  
East Hartford, Connecticut 06108



JUNE 1977  
FINAL REPORT



Prepared for

Department of Transportation  
Aviation Administration  
Research & Development Service  
Washington, D.C. 20590

National Aeronautics and  
Space Administration  
Lewis Research Center  
Cleveland, Ohio

1 Report No. FAA-RD-77-115		2 Government Accession No.		3 Recipient's Catalog No.	
4 Title and Subtitle EVALUATION OF FEDERAL AVIATION ADMINISTRATION ENGINE EXHAUST SAMPLING RAKE				5 Report Date June 1977	
				6 Performing Organization Code	
7 Author(s) A. J. Fiorentino, W. Greene, and R. Roberts				8 Performing Organization Report No. PWA-5534	
9 Performing Organization Name and Address United Technologies Corporation Pratt & Whitney Aircraft Group Commercial Products Division East Hartford, Connecticut 06108				10 Work Unit No.	
				11 Contract or Grant No. NAS3-19447	
12 Sponsoring Agency Name and Address Department of Transportation Federal Aviation Administration Washington, D. C. 20591				13 Type of Report and Period Covered Contractor Report	
				14 Sponsoring Agency Code Report No. NASA CR 135213	
15 Supplementary Notes Final report. Prepared under Interagency Agreement DOT-FA77WAI-708. Project Managers, Richard W. Niedzeiecki, NASA Lewis Research Center, Cleveland, Ohio, and John Tigue, DOT Federal Aviation Administration, Systems Research and Development Service, Washington, D. C.					
16 Abstract A FAA exhaust emissions rake was tested in the Experimental Clean Combustor Program, Phase III to permit comparison of the values of gaseous emissions and smoke measured by the FAA rake with those measured with the NASA/P&WA rake used in the Phase III Experimental Clean Combustor Program and with station 7 probes. The results showed that the levels of CO, THC, NO <sub>x</sub> and smoke measured by the FAA and NASA/P&WA rakes agree well at high power, but that CO emissions measured by the FAA rake were approximately 10 percent higher than those measured by the NASA/P&WA rake at low power.					
17 Key Words (Suggested by Author(s))  Emissions Standards Vorbix Combustor			18 Distribution Statement  Document is available to the U.S. public through the National Technical Information Service, Springfield, Virginia 22161. Unclassified - STAR Category 45		
19 Security Classif. (of this report) Unclassified		20 Security Classif. (of this page) Unclassified		21 No. of Pages 62	
				22 Price*	

\* For sale by the National Technical Information Service, Springfield, Virginia 22161

## **FOREWORD**

This document describes the work performed by the Commercial Products Division, Pratt & Whitney Aircraft Group of United Technologies Corporation under the Federal Aviation Administration Addendum to Phase III of the Experimental Clean Combustor Program. This final report was prepared for the Federal Aviation Administration in compliance with the requirements of Modifications No. 2 and No. 3 to National Aeronautics and Space Administration Lewis Research Center Contract NAS3-19447. This report has been assigned Commercial Products Division, Pratt & Whitney Aircraft Group internal report number PWA-5534.

## TABLE OF CONTENTS

	Page
SUMMARY	1
INTRODUCTION	2
CHAPTER I PROGRAM DESCRIPTION	3
A. Phase III Experimental Clean Combustor Program	3
B. Evaluation of Federal Aviation Administration Engine Exhaust Sampling Rate	3
C. Program Schedule	3
CHAPTER II EQUIPMENT AND EXPERIMENTAL PROCEDURES	5
A. Test Combustor	5
B. Experimental Engine X-686 Description	8
C. Exhaust Gas Sampling Instrumentation	11
D. Test Conditions and Procedures	17
E. Data Analysis Procedures	19
1. Emission Data Reduction Procedure	19
2. EPA Parameter Calculation	20
3. Combustor Performance Calculation Procedures	21
CHAPTER III RESULTS AND DISCUSSION	24
A. Introduction	24
B. Emission Results	24
1. Comparison of Emissions	24
2. EPAP and Smoke Results	28
C. Engine Performance	30
CHAPTER IV CONCLUSIONS	32
APPENDIX A EQUIPMENT AND EXPERIMENTAL PROCEDURES	33
APPENDIX B EMISSIONS AND PERFORMANCE DATA	52
APPENDIX C REFERENCES	54
APPENDIX D METRIC CONVERSION FACTORS	55

## LIST OF ILLUSTRATIONS

Figure	Title	Page
1	The Experimental Clean Combustor Program Schedule with the Federal Aviation Administration/Pratt & Whitney Aircraft Rake Elimination Program	4
2	Cross Section of Experimental Clean Combustor Program Phase III Vorbix Combustor	5
3	Vorbix Combustor Fuel Injector Arrangement	6
4	Phase III Vorbix Outer Combustor Liner	7
5	Phase III Vorbix Inner Combustor Liner on First-Stage Turbine Vane Assembly	8
6	Experimental JT9D-20 Engine X-686 With Vorbix Combustor and ARTS Instrumentation Ready for Initial Test - Right Side	9
7	Experimental JT9D-20 Engine X-686 With Vorbix Combustor and ARTS Instrumentation Ready for Initial Test - Left Side	9
8	Primary Exhaust Rake for Experimental Clean Combustor Program Phase III Test Program	11
9	Emissions Tailpipe Rake for Experimental Clean Combustor Program Phase III. Overall view of rake and support frame mounted in P-6 test stand	12
10	Station 7 Gas Sample Probe Array Used in the Experimental Clean Combustor Program and in the Federal Aviation Administration Test Program	13
11	Federal Aviation Administration Exhaust Sampling Rake Prior to Installation on Engine	14
12	Typical Engine Installation of Federal Aviation Administration Sampling Rake	15
13	Federal Aviation Administration Exhaust Sampling Rake Mounted on X-686 Experimental Engine in the P-6 Test Stand	16
14	Relative Indications of Gas Sampling Rakes for Oxides of Nitrogen Emissions	25
15	Relative Indications of Gas Sampling Rakes for Carbon Monoxide Emissions	25

### LIST OF ILLUSTRATIONS (Cont'd)

Figure	Title	Page
16	Relative Indications of Gas Sampling Pakes for Total Unburned Hydrocarbon Emissions	26
17	Comparison of Fuel/Air Ratios Determined By Carbon Balance Method From Various Gas Sampling Probes and By Direct Measurement of Fuel Flow and Airflow	27
18	Exit Radial Temperature Profile for the Vorbix Combustor at Idle and Sea Level Takeoff Conditions	27
19	Corrected Oxides of Nitrogen Emissions for the Vorbix Combustor Obtained With Different Sampling Systems	28
20	Corrected Carbon Monoxide Emissions for the Vorbix Combustor Obtained With Different Sampling Systems	29
21	Corrected Total Unburned Hydrocarbon Emissions for the Vorbix Obtained With Different Sampling Probes	29
22	Affect of Sampling Rake on Engine Performance	30

## LIST OF TABLES

Table	Title	Page
I	Standard Day JT9D-7A Gas Generator Conditions	17
II	Engine Test Program	18
III	JT9D-7A Engine Data for EPAP Calculation	21
IV	Summary of Reported Combustor Performance Parameters	21
V	Environmental Protection Agency Parameters and Smoke Results	30

## SUMMARY

The Federal Aviation Administration Rake Evaluation Program was conducted concurrently with, and as an addendum to, the NASA/P&WA Experimental Clean Combustor Program (ECCP), Phase III, during the last quarter of 1976. The objective was to compare the levels of gaseous emissions and smoke measured by the Federal Aviation Administration (FAA) rake with those measured by the National Aeronautics and Space Administration (NASA)/Pratt & Whitney Aircraft (P&WA) rake that was used to sample engine exhaust during the Phase III Experimental Clean Combustor Program and with Station 7 probes.

This program was accomplished in four tasks: Task I, Testing and Data Acquisition at a minimum of six power settings to establish a baseline using the National Aeronautics and Space Administration/Pratt & Whitney Aircraft cruciform rake; Task II, Installation of the FAA supplied rake on the engine tailpipe; Task III, Test and Data Acquisition at a minimum of ten test points including those conducted during Task I; and Task IV, Analysis of the Data and reporting.

The Federal Aviation Administration sponsored engine tests were conducted in a manner similar to that of other JT9D experimental engines at Pratt & Whitney Aircraft. Test stand inlet conditions were not artificially controlled so that the engine was run with various ambient temperature and barometric conditions and rarely on a "standard" day. Engine performance parameters were corrected to standard day conditions. Since the program was directed toward measurement of emissions at specific power levels, the steady state emissions data were taken for most points by establishing combustor inlet temperature level, regardless of ambient conditions. The emission data were corrected from the observed combustor inlet conditions to the corresponding standard day reference conditions for presentation in this report.

Under this addendum, approximately 6 hours of engine testing were conducted, consisting of 1.5 hours of emission acquisition with Station 7 probes and the NASA/P&WA 24-point channel rake and 4.6 hours of emissions acquisition with the Station 7 probes and the FAA exhaust emission rake. Both emission tests were conducted with the two-stage Vorbix combustor installed in experimental JT9D engine X-686.

The principal conclusions derived from this work are:

- The CO, THC, NO<sub>x</sub>, and smoke data obtained from the FAA and NASA/P&WA rakes agree well at high power.
- At low power levels (idle and approach), the CO emissions measured by the FAA rake were approximately 10 percent higher than those measured by the NASA/P&WA rake.
- The FAA rake evaluated in this program produces measurable tailpipe blockage and consequent engine performance shifts. The performance shifts had negligible affect on setting engine conditions and did not impact emission measurements.



## INTRODUCTION

The objective of this addendum to the Phase III Experimental Clean Combustor Program (Reference 1) was the evaluation of a Federal Aviation Administration-supplied engine exhaust sampling rake installed behind an experimental JT9D engine. The Federal Aviation Administration rake is diamond shaped and is attached directly to the core engine tailpipe with its sampling plane 3 inches downstream of the tailpipe exit. This rake design has been used to measure emission from several aircraft gas turbine engines in the field including the Pratt & Whitney Aircraft low-bypass JT3D and JT8D models and the core exhaust of the JT9D.

This addendum utilized the large amount of data generated in the Experimental Clean Combustor Program for a "low emissions" type two-stage Vorbix combustor using an 8-arm rake mounted 14-inches back of the tailpipe free of the engine and compare with the data collected using the Federal Aviation Administration rake for this type of combustor. The data collected by both the National Aeronautics and Space Administration and the Federal Aviation Agency rakes were compared with the data collected from probes which are normally used to measure turbine exit total pressure.

A summary of the program plan and schedule is provided in Chapter I. Chapter II contains a description of the reference engine (JT9D-7A) and gas sampling rakes used in this program; and a description of the test and analyses procedures. The program results are discussed in Chapter III and concluding remarks are presented in Chapter IV. Additional information concerning equipment and experimental procedures is contained in Appendix A. Experimental data are tabulated in Appendix B. References are provided in Appendix C.

ORIGINAL PAGE IS  
OF POOR QUALITY

## **CHAPTER I**

### **PROGRAM DESCRIPTION**

#### **A. PHASE III EXPERIMENTAL CLEAN COMBUSTOR PROGRAM**

The Phase III program, recently completed, consisted of a detailed evaluation of a low pollution combustor and associated fuel system components in a JT9D engine. The test program included steady-state pollution and performance evaluations, as well as transient acceleration and deceleration engine operation. Details of the Phase III work are contained in Reference 1.

#### **B. EVALUATION OF FEDERAL AVIATION ADMINISTRATION ENGINE EXHAUST SAMPLING RAKE**

The Federal Aviation Administration Rake Evaluation Program was conducted concurrently with, and as an addendum to, the Experimental Clean Combustor Program (ECCP) Phase III contract during the last quarter of 1976. The object of this addendum was to provide the experimental data and analysis whereby the levels of gaseous emissions and smoke measured by the Federal Aviation Administration (FAA) rake could be compared to the National Aeronautics and Space Administration/Pratt & Whitney Aircraft rake that was used to sample engine exhaust during the Phase III Experimental Clean Combustor Program and with Station 7 probes.

This program was accomplished in four tasks: Task I, Testing and Data acquisition at a minimum of 6 power settings to establish a baseline using the National Aeronautics and Space Administration/Pratt & Whitney Aircraft cruciform rake; Task II, installation of the Federal Aviation Administration supplied rake on the engine tailpipe; Task III, testing and data acquisition at a minimum 10 test points including those conducted during Task I; and Task IV, the analysis of the data and reporting.

#### **C. PROGRAM SCHEDULE**

The Experimental Clean Combustor Program schedule with the Federal Aviation Administration/Pratt & Whitney Aircraft Rake Evaluation Program is presented in Figure 1 along with the overall Phase III Experimental Clean Combustor Program.

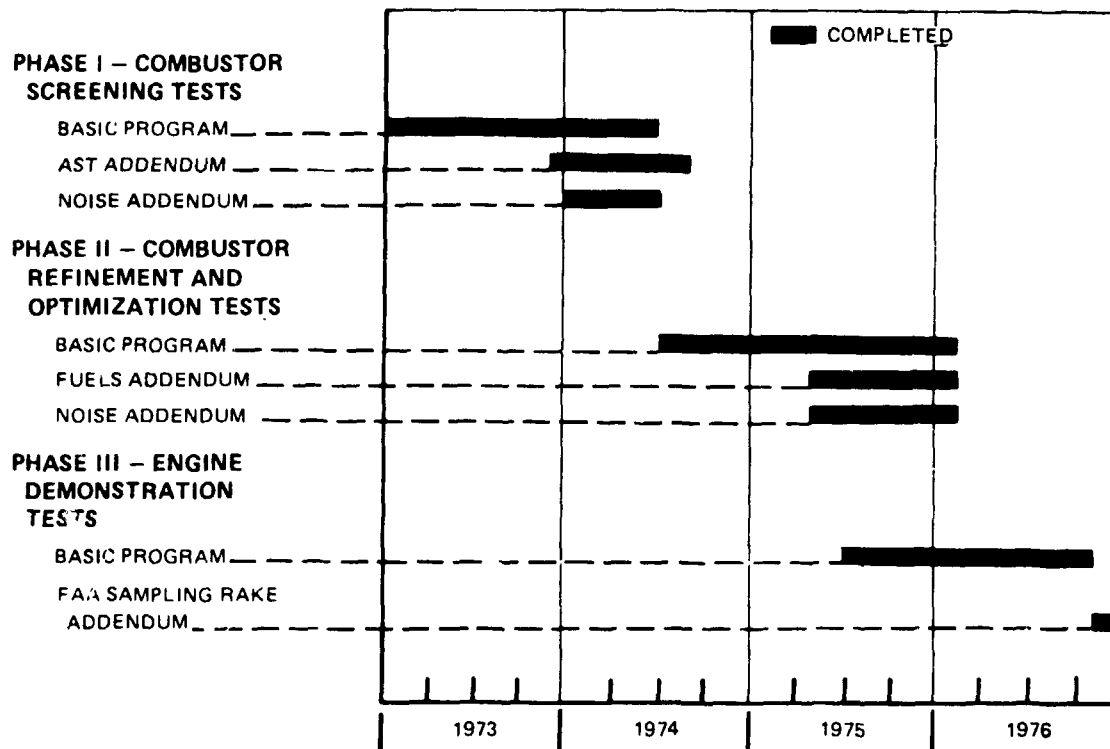


Figure 1 The Experimental Clean Combustor Program Schedule With the Federal Aviation Administration/ Pratt & Whitney Aircraft Rake Evaluation Program

ORIGINAL PAGE IS  
OF POOR QUALITY

## CHAPTER II

### EQUIPMENT AND EXPERIMENTAL PROCEDURES

#### A. TEST COMBUSTOR

A cross section drawing of the Phase III Vorbix (vortex burning and mixing) combustor is shown in Figure 2. A front view of the pilot fuel system arrangement and the circumferential location of the pilot and main fuel injectors is shown in Figure 3. Figure 4 presents a photograph of the outer combustor liner and head assembly after installation of the hood. The inner combustor liner is shown in Figure 5 mounted on the instrumented first-stage turbine vane assembly.

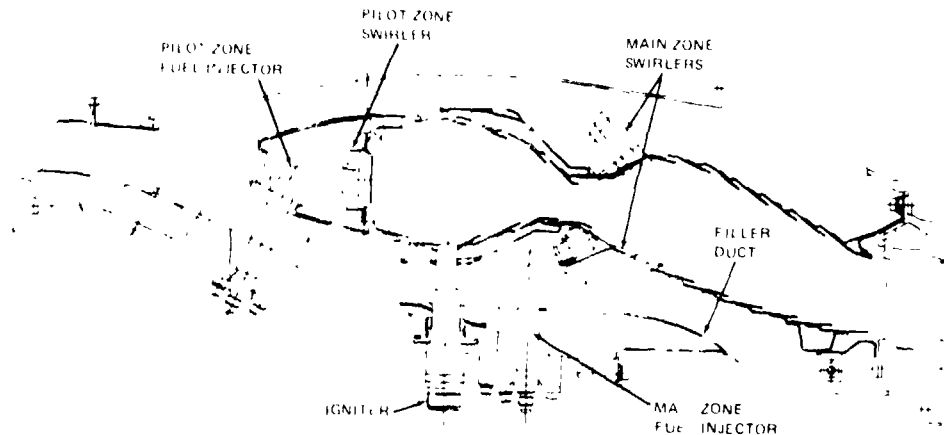


Figure 2 Cross Section of Experimental Clean Combustor Program Phase III Vorbix Combustor

The vortex concept incorporates two burning zones separated axially by a high velocity throat section. The pilot zone is a conventional swirl-stabilized, direct-injection combustor employing thirty fuel injectors. It is sized to provide the required heat release rate for idle operation at high efficiency. Emissions of carbon monoxide and unburned hydrocarbons are minimized at idle operating conditions primarily by maintaining a sufficiently high pilot zone equivalence ratio to allow complete burning of the fuel.

At high power conditions, the pilot exhaust equivalence ratio is reduced as low as 0.3 (including pilot dilution air) to minimize formation of oxides of nitrogen. The minimum equivalence ratio for the pilot zone is determined by the overall lean blowout limits, combustion efficiency, and the need to maintain sufficient pilot zone temperature to vaporize and ignite the main zone fuel. Main zone fuel is introduced through fuel injectors located at the outer wall of the liner downstream of the pilot zone discharge location. Sixty fuel injectors are used. Main zone combustion and dilution air is introduced through sixty swirlers positioned on each side of the combustor (120 total).

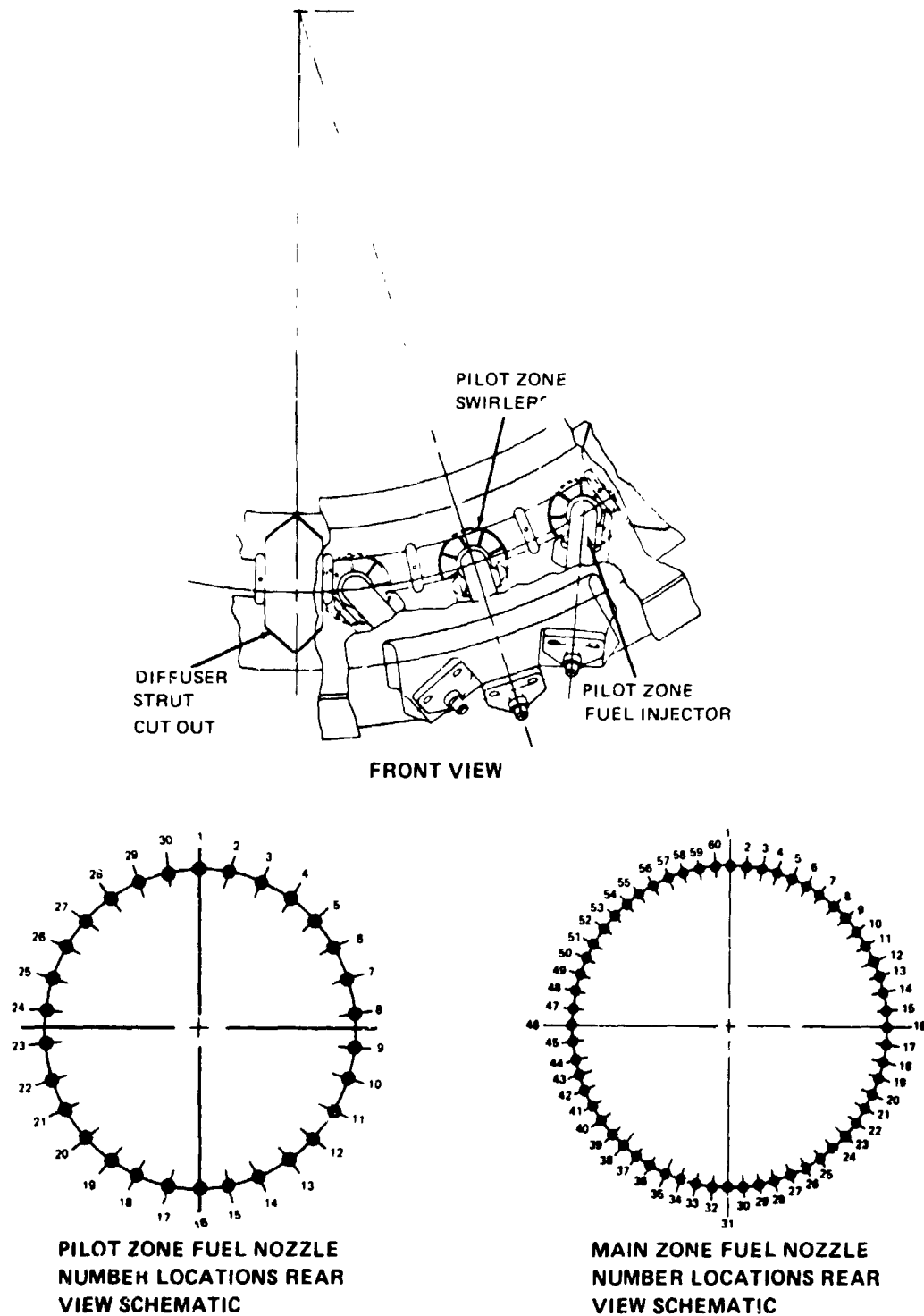
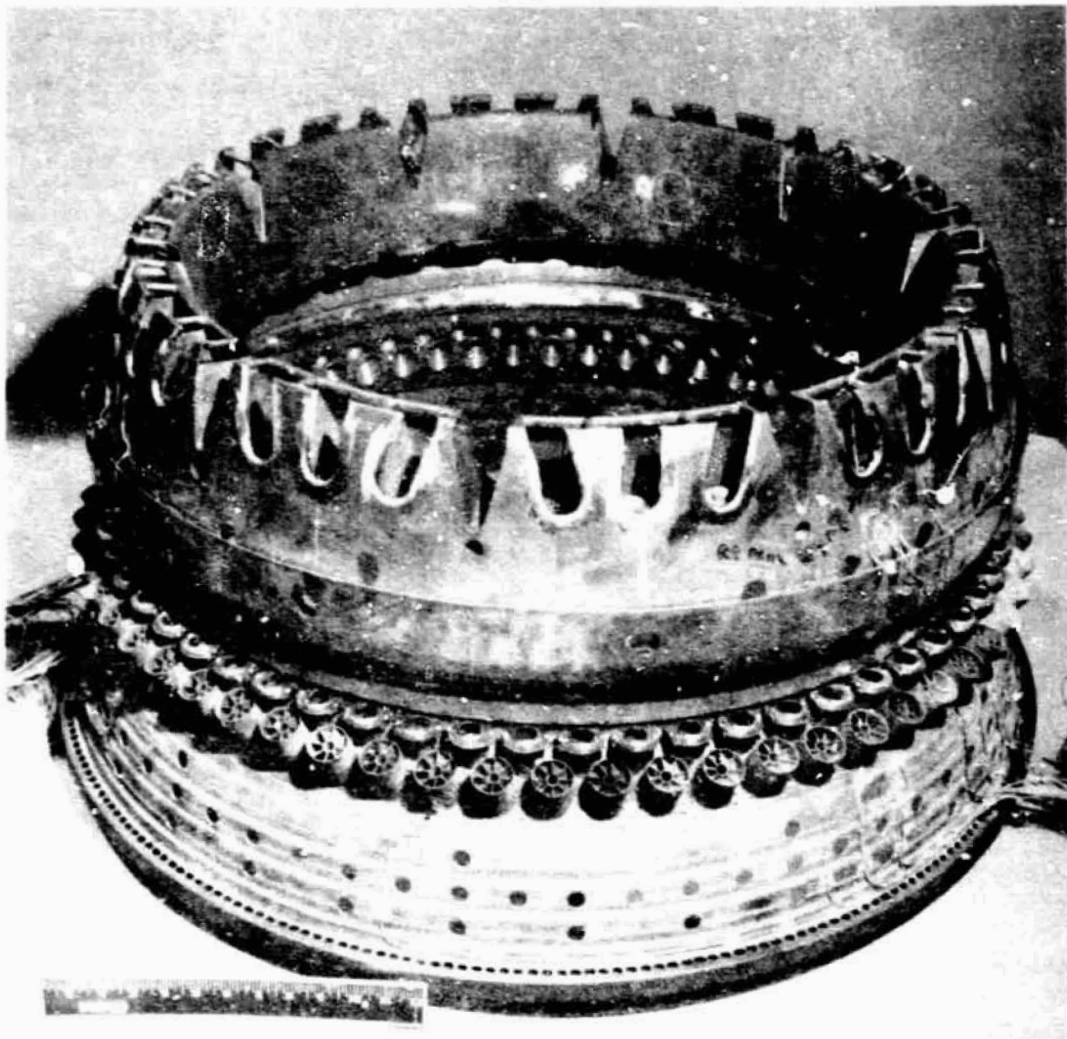
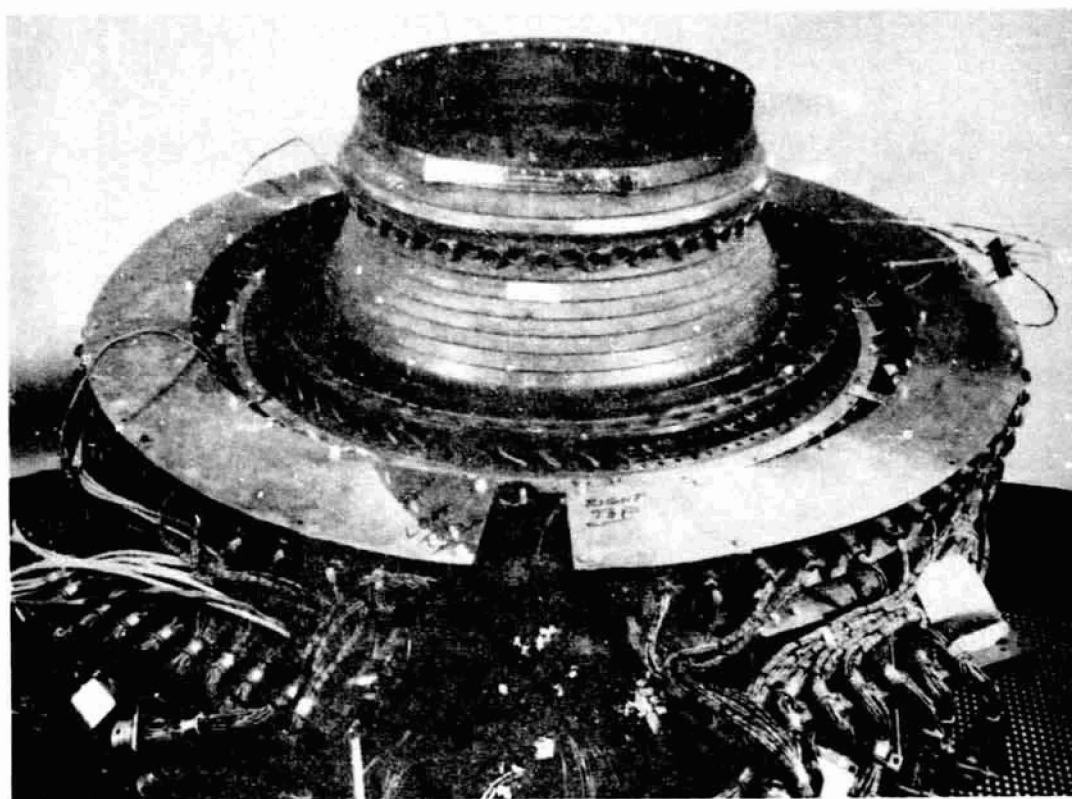


Figure 3 Vorvix Combustor Fuel Injector Arrangement



*Figure 4 Phase III Vorbix Outer Combustor Liner (XPN-59997)*

ORIGINAL PAGE IS  
OF POOR QUALITY



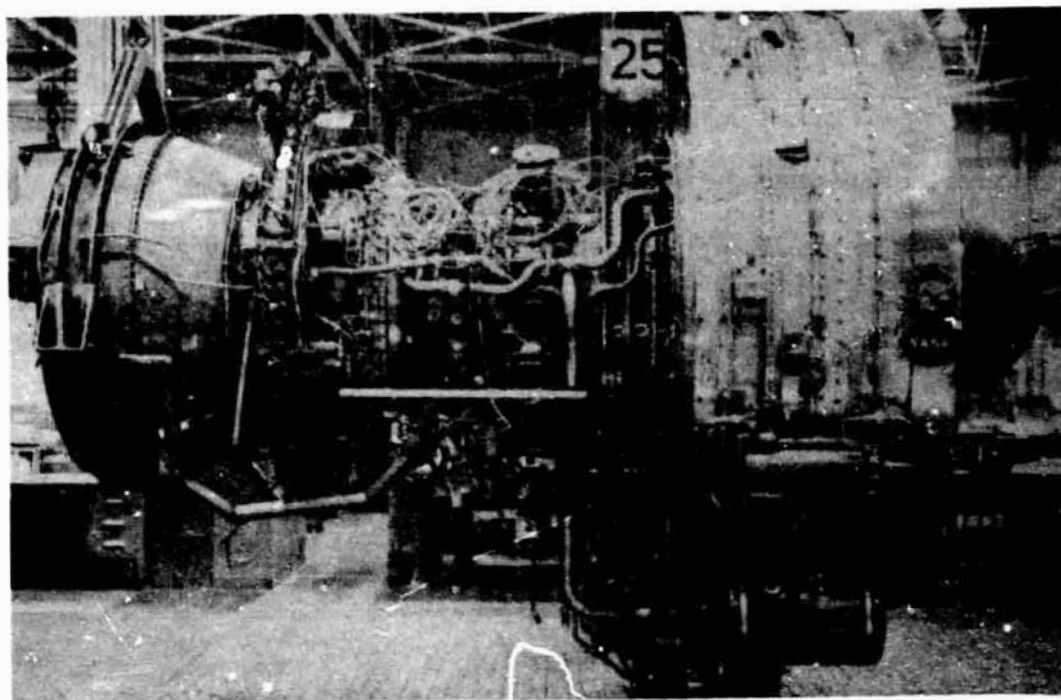
*Figure 5 Phase III Vorbix Inner Combustor Liner on First-Stage Turbine Vane Assembly (XPN-59678)*

## **B. EXPERIMENTAL ENGINE X-686 DESCRIPTION**

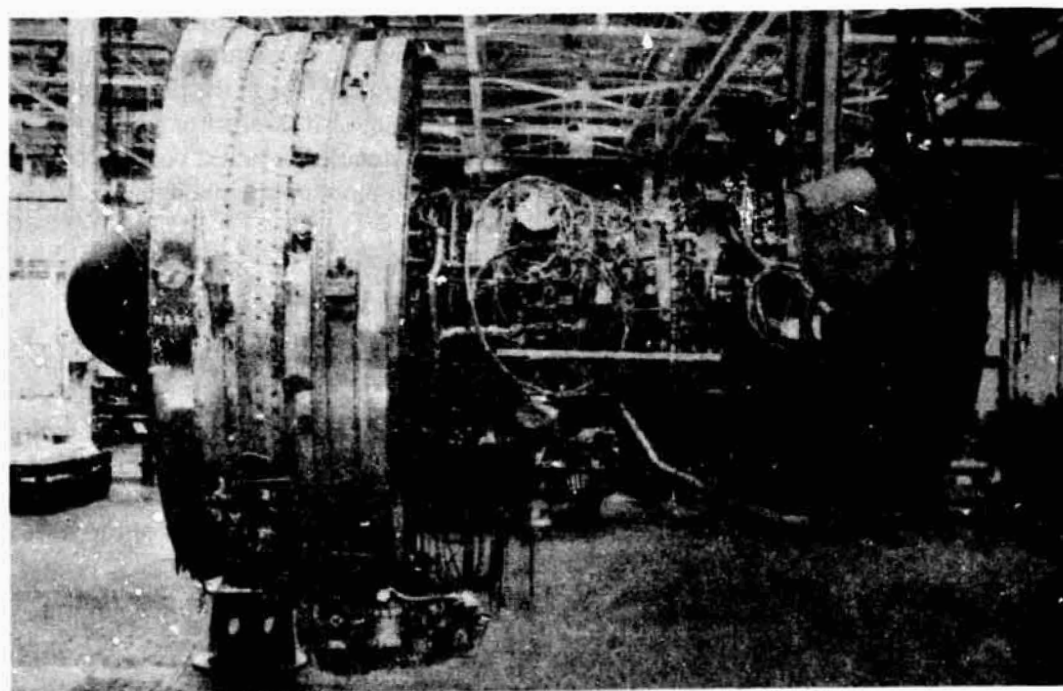
### **Engine Configuration**

Experimental JT9D-20 engine X-686 was designated as the test vehicle for the Phase III Experimental Clean Combustor Program. The JT9D-20 engine model is equivalent to the JT9D-7A reference engine in gas generator configuration and performance. The major differences between the two models are the locations of the mounting attachment points, accessory gearbox, and other external components. The JT9D-20 model is preferred to combustor development work because the gearbox is located forward and away from the combustor case. The design of experimental fuel manifolds and instrumentation is considerably simplified by removal of the JT9D-7 envelope constraints, and the external components are easily accessible for service. The engine was operated at JT9D-7A combustor inlet parameters and thrust levels for the Phase III test program.

Figures 6 and 7 show external views of engine X-686 prior to the start of Phase III testing. The two-stage Vorbix external fuel system is visible, as is the first-stage turbine inlet guide vane Automatic Recording Temperature System (ARTS) instrumentation package.



*Figure 6 Experimental JT9D-20 Engine X-686 With Vorbix Combustor and ARTS Instrumentation  
Ready for Initial Test - Right Side (CN-57359)*



*Figure 7 Experimental JT9D-20 Engine X-686 With Vorbix Combustor and ARTS Instrumentation  
Ready for Initial Test - Left Side (CN-57360)*

ORIGINAL PAGE IS  
OF POOR QUALITY



## Performance Instrumentation

In order to compute overall performance characteristics, experimental engine X-686 was instrumented to measure the following engine operating parameters.

- Engine inlet temperature -  $T_{t2}$
- Low rotor speed -  $N_1$
- High rotor speed -  $N_2$
- Gearbox breather pressure -  $P$
- Gearbox breather temperature -  $T$
- Engine thrust  $F_N$
- Engine inlet total pressure -  $P_{T2}$
- Fan discharge total pressure -  $P_{t2.5}$
- Engine exit total pressure -  $P_{t7}$
- High turbine discharge temperature -  $T_{t6}$
- Engine exit total temperature -  $T_{t7}$
- Burner pressure -  $P_{s4}$
- Total engine fuel flow -  $W_f$

In addition, pressure and temperature probes were added to the compressor discharge station to measure combustion inlet conditions; extensive instrumentation (total and static pressure taps) was added to the diffuser/combustor section to establish airflow distribution into the combustor; thermocouples were installed at critical locations on the combustor liner skin for monitoring these areas and gas samples were withdrawn through taps at the downstream end of the ID and OD diffuser shroud passages and passed through a hydrocarbon analyzer to detect internal fuel leakage, fuel aspiration, or combustor damage should it occur. The engine and combustor section instrumentation is described in more detail in Appendix A.

## P-6 Test Stand

All engine testing under the Phase III Experimental Clean Combustor Program was conducted at the Pratt & Whitney Aircraft production test facility in Middletown, Connecticut. This facility includes a series of ambient inlet, indoor test cells with sufficient cell volume and flow capacity to test high airflow engines in the JT9D thrust class. The P-6 test stand has been equipped with the additional instrumentation and data handling capability required for ARTS and low-emission combustor development programs. A description of the test stand and data acquisition system is given in Appendix A.

### C. EXHAUST GAS SAMPLING INSTRUMENTATION

Three gas sampling techniques were used to obtain the engine exhaust emission data during this program.

The primary means of exhaust gas sample acquisition during the Phase III Experimental Clean Combustor Program was a rake assembly having eight radial arms spaced at 45 degree intervals mounted in the core engine exhaust stream 0.36m (14 inches) downstream of the exhaust nozzle exit plane. The unmounted rake shown in Figure 8 was designed for use with a JT9D experimental tailpipe (cylindrical section). Twenty-four sampling ports are located on eight radial arms at the center of equal areas. All 24 ports were manifolded together while the sampling rake was kept stationary in a support frame mounted in the P-6 engine test cell as shown in Figure 9.

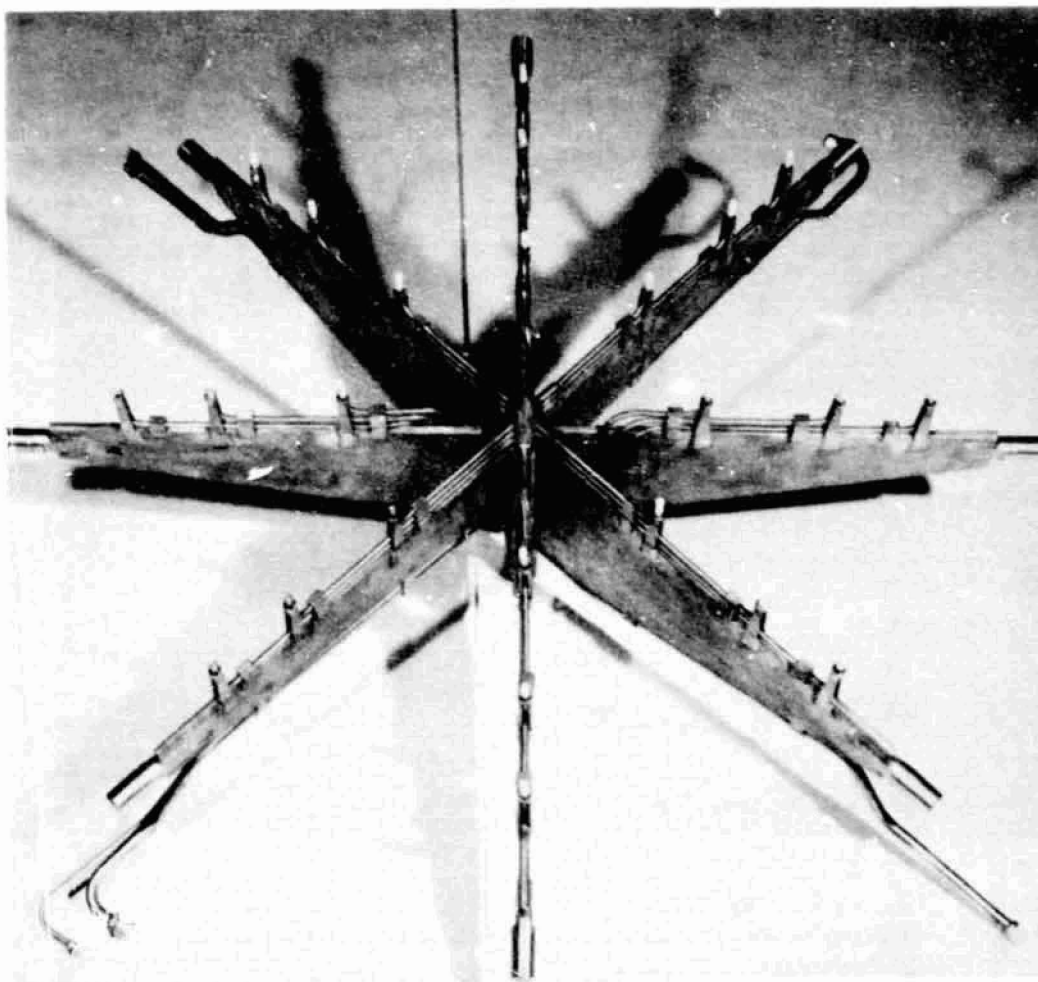
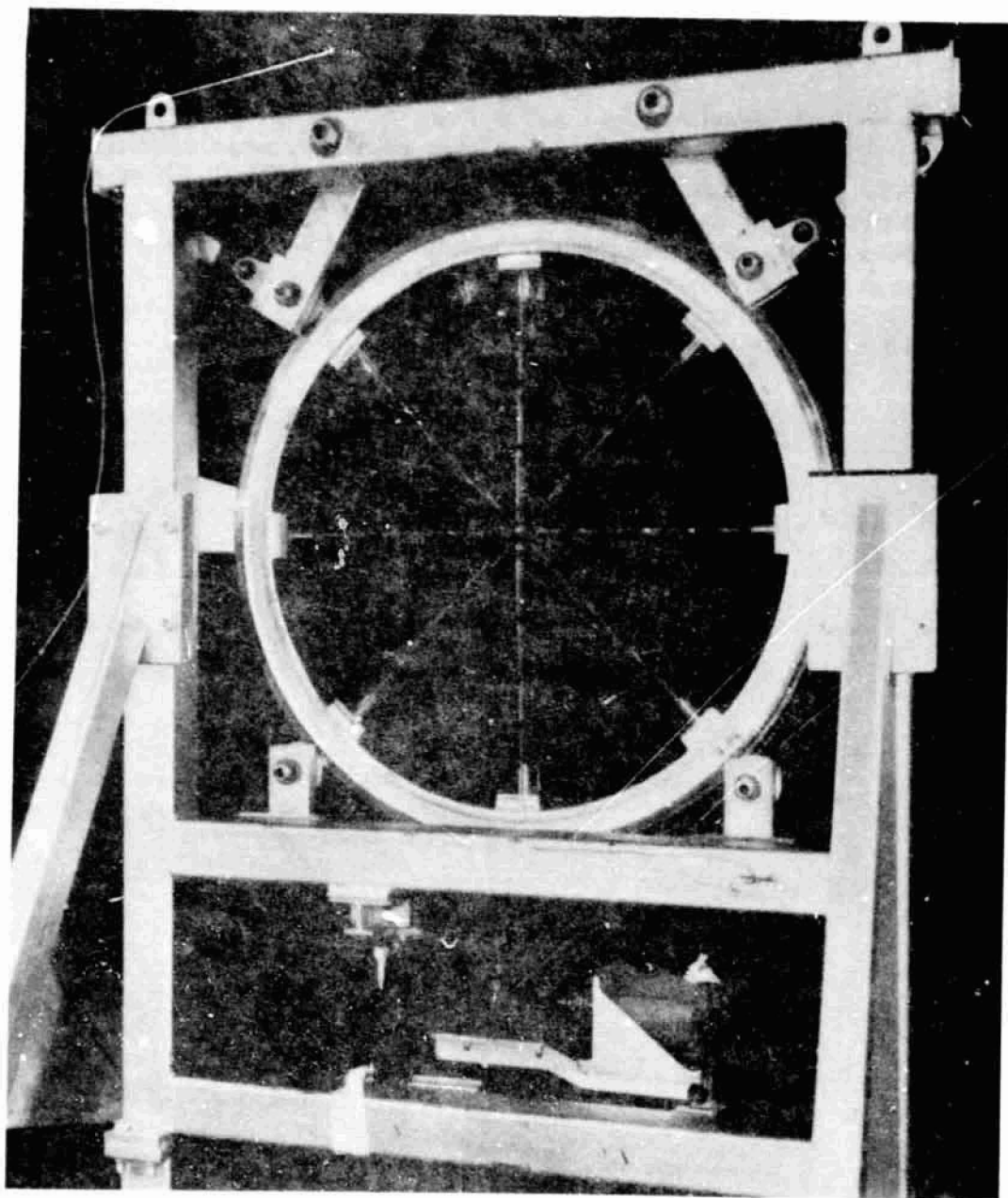


Figure 8 Primary Exhaust Rake for Experimental Clean Combustor Program Phase III Test Program (XPN-59484)



*Figure 9 Emissions Tailpipe Rake and Support Frame Used for Experimental Clean  
Combustor Program Phase III  
(CN-57539)*

An additional exhaust gas sampling system utilized for comparison purposes in this program as well as in the Phase III test programs [Reference 1], consisted of the standard production engine exhaust total pressure probes. These were six Station 7 pressure probes each with 8 radial pressure taps manifolded to deliver a single gas sample to the analysis equipment. The circumferential and radial positions of the sampling ports are shown in Figure 10.

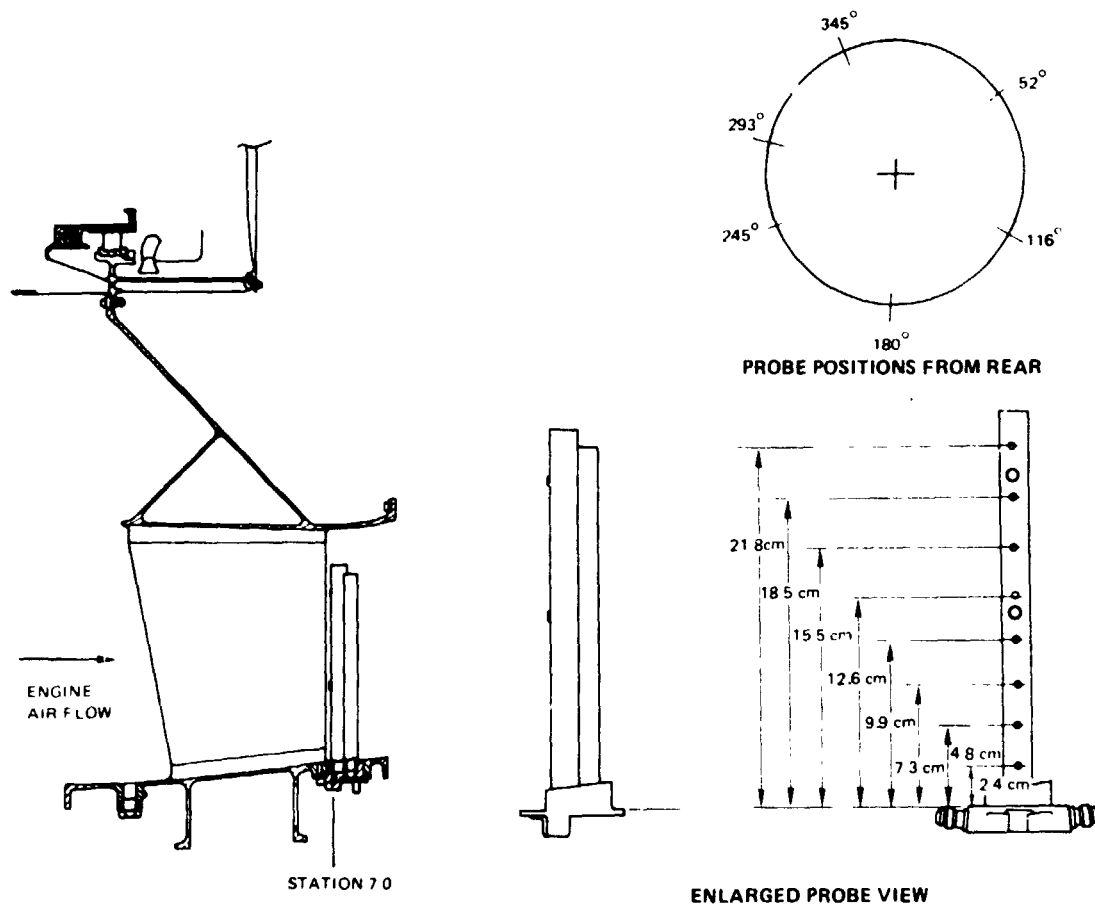
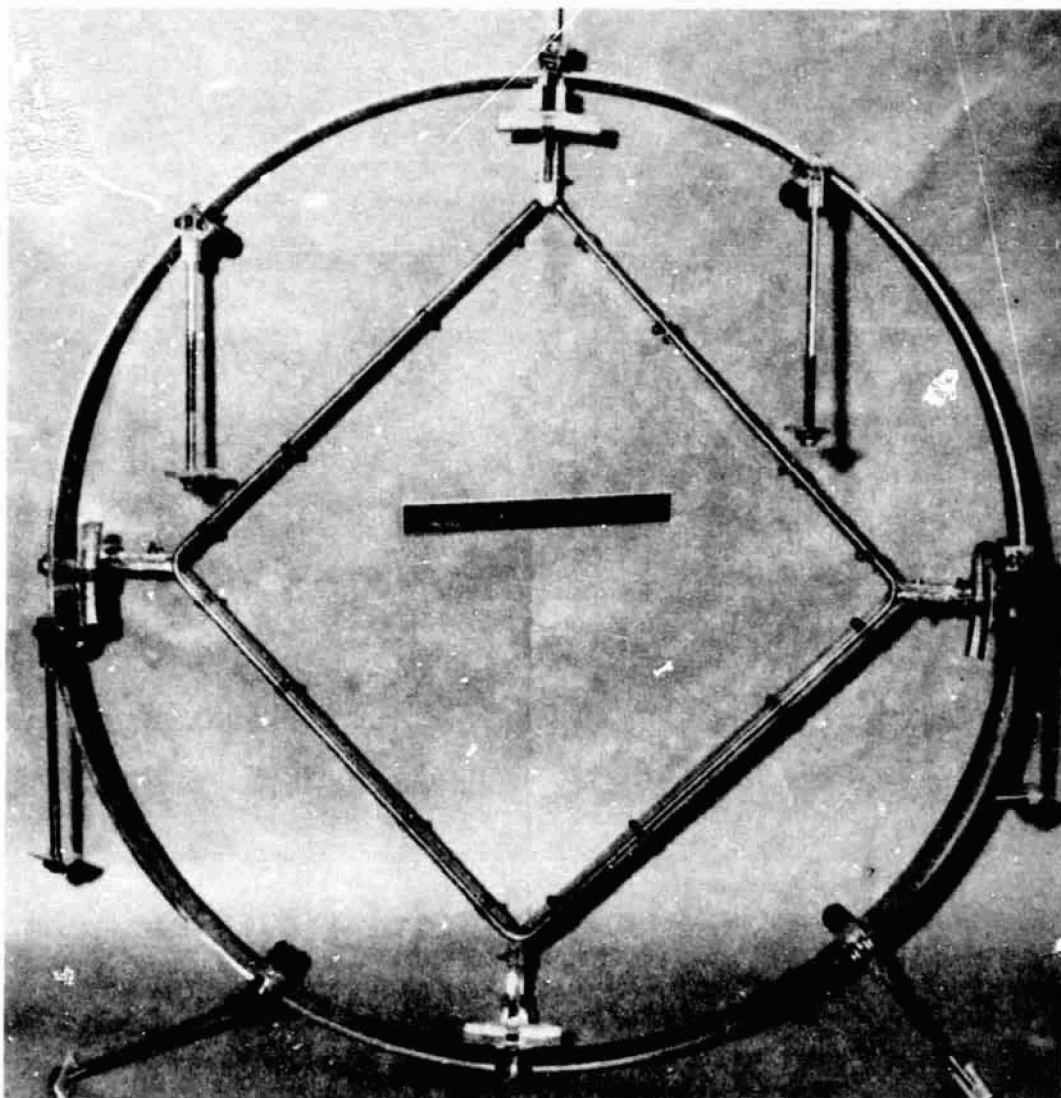


Figure 10 Station 7 Gas Sample Probe Array Used in the Experimental Clean Combustor Program and in the Federal Aviation Administration Test Program

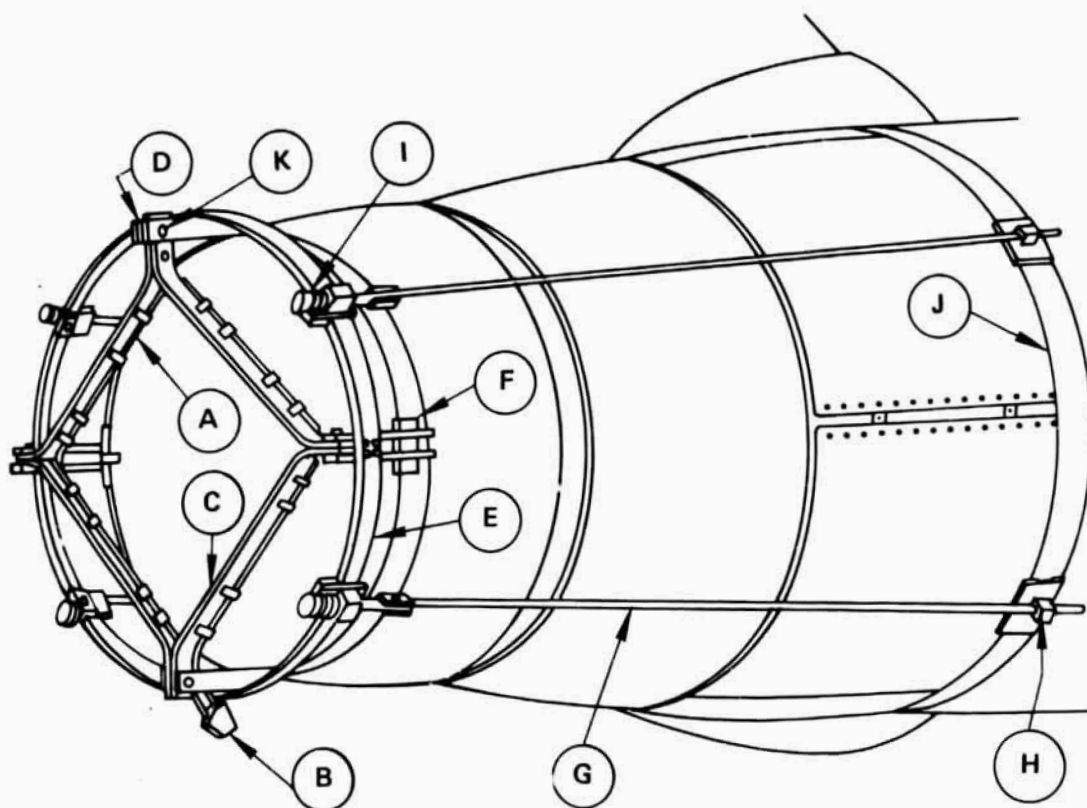
The Federal Aviation Administration supplied rake, shown in Figure 11, was intended for use on an installed aircraft gas turbine engine with nacelle. The diamond configuration was designed to clear the exhaust nozzle centerbody, common to several nacelle installations, including the JT9D. The diamond rake evaluated in this program was sized to fit the cylindrical tailpipe (no centerbody) normally used in JT9D experimental engine testing. Each side of the diamond shaped rake contains three sampling ports of equal size (approximately 8.99 mm (0.035 inch) diameter) manifolded to a single heated line. The typical arrangement recommended by the Federal Aviation Administration for locating and securing the sampling probe to the exhaust nozzle is shown diametrically in Figure 12. This arrangement enables concentric placement of the probe with the exhaust nozzle with allowance for radial thermal

expansion and minimal interference with the nozzle flow area. The assembly is positioned on the nozzle rim with four equispaced mounting pads and secured with four tension rods between the thrust reverser forward shroud and the torsional support ring attached to the clevis pieces. Thermal expansion of the exhaust nozzle is taken up by compression of springs at the aft end of the tension rods. The complete rake installation on the experimental engine used in this program, shown in Figure 13, resulted in the sampling plane being located approximately 7.62 cm (3 inches) downstream of the tailpipe exit.

A detailed description of the gas analysis and conditioning equipment is presented in Appendix A.



*Figure 11 Federal Aviation Administration Exhaust Sampling Rake Prior to Installation on Engine  
(76-441-4072-A)*

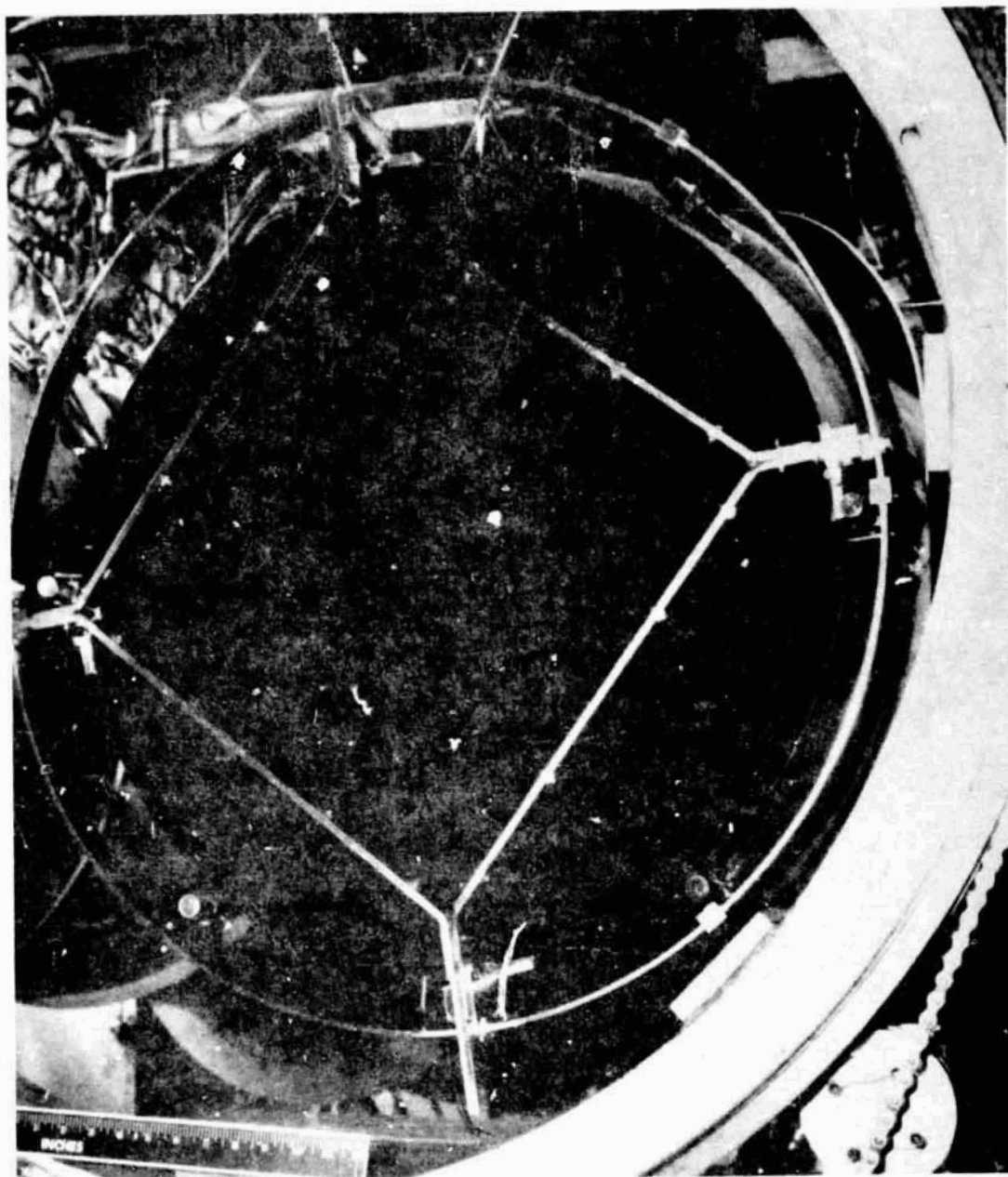


**LEGEND:**

- A. PROBE TUBE
- B. PROBE OUTLET MANIFOLD
- C. PROBE BACK-UP STRUCTURE
- D. PROBE MOUNT CLEVIS
- E. TORSIONAL SUPPORT RING
- F. CLEVIS MOUNT PAD
- G. TENSIONING ROD
- H. TENSIONING ROD ADJUSTING NUT
- I. THERMAL EXPANSION SPRING
- J. REVERSER FORWARD SHROUD
- K. PROBE ATTACH BOLTS

*Figure 12 Typical Engine Installation of Federal Aviation Administration Sampling Rake*





*Figure 13 Federal Aviation Administration Exhaust Sampling Rake Mounted on X-686  
Experimental Engine*

76-441-4072-D

ORIGINAL PAGE IS  
OF POOR QUALITY

## D. TEST CONDITIONS AND PROCEDURES

The Federal Aviation Administration sponsored engine tests were conducted in a manner similar to that of other JT9D experimental engines at Pratt & Whitney Aircraft. Test stand inlet conditions are not artificially controlled so that the engines are run during various ambient temperature and barometric conditions and rarely on a "standard" day. Engine performance parameters are normally corrected to standard day conditions (Appendix A). Since the nature of this program was oriented to measurement of emissions at specific power levels, the steady state emissions data were taken for most points by establishing combustor inlet temperature level, regardless of ambient conditions. The Standard Day JT9D-7A Gas Generator Reference Conditions are tabulated in Table I for the four EPA-specified sea level static power settings. The emission data were corrected from the observed combustor inlet conditions to the corresponding standard day reference conditions for presentation in this report.

TABLE I  
STANDARD DAY JT9D-7A GAS GENERATOR  
REFERENCE CONDITIONS

Engine Model	EPA Power Level	Thrust		Inlet Fuel Flow		Combustor Inlet Temperature		Combustor Inlet Pressure		Combustor Fuel-Air Ratio
		N	lbf	kg/hr	lbm/hr	K	°F	N/m <sup>2</sup>	psia	
JT9D-7A	Idle	14,234	3,200	780	1,720	447	345	3.69x10 <sup>5</sup>	53	0.0105
	Approach	61,585	13,845	2,109	4,650	588	598	8.91x10 <sup>5</sup>	129	0.0134
	Climb	174,494	39,228	6,010	13,250	736	864	19.38x10 <sup>5</sup>	281	0.0206
	Takeoff	205,284	46,150	7,303	16,100	764	916	21.68x10 <sup>5</sup>	323	0.0229

Table II presents two successive programs formulated to evaluate the Federal Aviation Administration rake sampling ability relative to the cruciform rake and the Station 7 rake which was used to accumulate most of the emission data during the Phase III Experimental Clean Combustor Program. After approximately a five minute stabilization period at each test point, a set of engine performance data, combustor section pressure, and exhaust gas emission data were simultaneously recorded. Smoke samples were only taken at higher power settings as indicated.



TABLE II  
ENGINE TEST PROGRAM

Engine Run Point	Emissions Rate (CO, THC, & NO <sub>x</sub> )		Engine Condition	Temperature - T <sub>4</sub> (°K) (°F)		Percent Pilot Fuel	Smoke	
	24 Pt	ST-7		(°K)	(°F)		24 Pt	FAA
1	X	X	*SLTO	748	887	28	X	
2	X	X	Climb	718	832	34	X	
3	X	X	Sub Climb	665	737	36		
4	X	X	Approach	576	577	50		
5	X	X	High Idle	483	409	100		
6	X	X	Idle	439	331	100		
Removed 24 Pt Rate and Installed FAA Rate								
7		X	Idle	448	346	100		
8		X	Max. Thrust	759	906	27		X
9		X	Climb Pilot Fuel Split	741	874	33		
10		X	Climb	729	853	34		X
11		X	Climb Pilot Fuel Split	744	880	29		X
12		X	Climb Pilot Fuel Split	740	872	21		X
13		X	Sub Climb	703	805	34		X
14		X	High Approach	669	745	36		
15		X	Approach Pilot Fuel Split	583	589	51		
16		X	Approach Pilot Fuel Split	581	586	41		
17		X	Approach Pilot Fuel Split	582	588	61		
18		X	Approach Pilot Fuel Split	582	588	84		
19		X	Idle	437	327	100		
20		X	Idle	451	352	100		
21		X	Idle	491	423	100		

\*Maximum safe operating conditions

## E. DATA ANALYSIS PROCEDURES

### 1. Emission Data Reduction Procedure

The raw emission data generated at each test condition were transmitted directly to an on-line computer for processing. The voltage response of the gaseous constituent analyzers were converted to an emission concentration, based on the calibration curves of each instrument, and then used to calculate emission indices, carbon balance fuel/air ratio, and combustion efficiency. The emission index and carbon balance fuel/air ratio calculations were performed in accordance with the procedures established in SAE ARP 1256 [Reference 2].

In order to compare combustor development engine emission data between runs, it is necessary to correct emission data to the standard conditions listed in Table I. The basis for setting most test points was combustor inlet temperature ( $T_{t4}$ ). All adjustment of observed emission data were made relative to the observed value of combustor inlet temperature, thereby obviating the need to make an inlet temperature correction. Curves of correction for inlet pressure, fuel/air ratio, and combustor reference velocity versus inlet temperature were generated for the reference JT9D-7A engine operating at standard day ambient conditions.

Comparison of observed and reference combustor operating conditions for the steady-state tests in experimental engine X-686 revealed that only inlet pressure deviated significantly from the reference engine characteristics. Deviations up to 10 percent were recorded at high power engine conditions. Deviations were less than 12 percent at low power conditions. The observed combustor reference velocity was essentially identical to the standard engine characteristic, and the fuel/air ratio was only slightly (0-3 percent) higher than the standard engine. In view of the relative imprecision of currently available fuel/air ratio correction factors and the demonstrated dependence on combustor configuration, it was decided not to attempt a fuel/air corrections. In addition, the  $\text{NO}_x$  data were corrected to a standard inlet air humidity of 6.3 g  $\text{H}_2\text{O}$ /kg dry air. The data adjustment equations for the gaseous emission species are as follows:

$$(1) \text{ NO}_x \text{ corr.} = \text{NO}_x \text{ meas.} \frac{(P_{t4} \text{ std.})^{0.5}}{(P_{t4} \text{ meas.})} e^{0.0188 (H \text{ meas.} - 6.3)}$$

$$(2) \text{ CO corr.} = \text{CO meas.} \frac{(P_{t4} \text{ meas.})}{(P_{t4} \text{ std.})}$$

$$(3) \text{ THC corr.} = \text{THC meas.} \frac{(P_{t4} \text{ meas.})}{(P_{t4} \text{ std.})}$$

where:

$\text{NO}_x$  = Emission index of oxides of nitrogen (g/kg fuel)

CO = Emission index of carbon monoxide (g/kg fuel)

THC = Emission index of total hydrocarbons (g/kg fuel)

ORIGINAL PAGE 1:  
OF POOR QUALITY

$P_{t4}$  = Combustor inlet total pressure  
 $H$  = Inlet specific humidity (g  $H_2O$ /kg air)

and subscripts:

corr. = Relates to value at corrected or standard condition  
 meas. = Relates to value at measured condition

Exhaust smoke data are presented on an as-recorded basis, due to the lack of suitable extrapolation information. As was indicated above, the only significant deviation when presented on an inlet temperature basis is in combustor inlet pressure. An increase in pressure to the correct standard engine level would be expected to increase exhaust smoke.

## 2. EPA Parameter Calculation

The U. S. Environmental Protection Agency emission standards for aircraft engines are expressed in terms of an integrated EPA parameter (EPAP). This parameter combines emission rates at the engine idle, approach, climb, and takeoff operating modes, integrated over a specified landing, takeoff cycle [Reference 3]. The equation for this calculation is as follows:

$$(4) \text{ EPAP}_i = \frac{\sum_j \frac{t_j}{60} W_{Fj} \text{EL}_{ij}}{\sum_j \frac{t_j}{60} F_{Nj}} \text{ (lbm pollutant/1000 lbf thrust-hr/LTO cycle)}$$

where:

$\text{EI}$  = emission index (lbm pollutant/1000 lbm fuel)  
 $t$  = time at engine mode (min)  
 $F_N$  = net thrust (lbf)  
 $W_F$  = fuel flow rate (lbm/hr)

and subscripts:

$i$  = emission category (CO, THC,  $\text{NO}_x$ )  
 $j$  = engine mode (idle, approach, climb, SLTO)

The engine data used to calculate the EPAP, presented in Table III, were obtained from the latest JT9D-7A performance table.

TABLE III

## JT9D-7A ENGINE DATA FOR EPAP CALCULATION

Engine Mode	Time (t) min	Net Thrust ( $F_n$ ) lbf	Fuel Flow ( $W_f$ ) lbm/hr
Idle	26.0	3200	1720
Approach	4.0	13845	4650
Climb	2.2	39228	13250
SLTO	0.7	46130	16100

Substituting the engine data from Table IV equation (4) becomes:

$$(5) \text{ EPAP}_i = 0.174EI_{\text{Idle}} + 0.072EI_{\text{approach}} + 0.114EI_{\text{climb}} + 0.0441EI_{\text{SLTO}}$$

The emission indices used in equation (5) are obtained from plots versus inlet temperature at the JT9D-7A four values of combustor inlet temperature corresponding to the EPA power points (Table I).

### 3. Combustor Performance Calculation Procedure

Measured and calculated combustor performance parameters are listed in Table IV.

TABLE IV

## SUMMARY OF REPORTED COMBUSTOR PERFORMANCE PARAMETERS

Parameter	Symbol	Units	Measured	Calculated
Total Airflow	$W_{a4}$	kg/s	X	
Total Combustor Airflow	$W_{ab}$	kg/s		X
Pilot Fuel Flow	$W_{f \text{ pilot}}$	kg/s	X	
Main Fuel Flow	$W_{f \text{ main}}$	kg/s	X	
Inlet Total Temperature	$T_{t4}$	K	X	
Inlet Total Pressure	$P_{t4}$	atm	X	
Reference Velocity	$V_{\text{ref}}$	m/s		X
Pattern Factor	PF			X
Inlet Air Humidity	H	gH <sub>2</sub> O/kg air	X	
Fuel/Air Ratio	$f/a$			X
Pressure Loss	$\Delta T_t/P_t$			X
Combustion Efficiency	$\eta_c$	%		X

Definitions of those calculated parameters which require further clarification are presented below.

#### a. Total Combustor Airflow

The total combustor airflow is determined by subtracting the turbine cooling air and other fixed bleed flows from the measured engine air flow.

#### b. Reference Velocity

The reference velocity ( $V_{ref}$ ) is defined as that flow velocity that would result if the total combustor airflow, at the compressor discharge temperature and static pressure, were passed through the combustor liner at the maximum cross sectional area. This area is  $0.218\text{m}^2$  for the Vorbix combustor tested in this program.

#### c. Fuel/Air Ratio

Both measured and carbon derived fuel/air ratios ( $f/a$ ) have been calculated and recorded for all test points run in this program. The measured, or performance fuel/air ratio, is the ratio of total fuel flow to total combustor airflow. The pilot and main fuel/air ratios are defined by multiplying the overall fuel/air ratio by the fractional pilot and main fuel split, respectively. The carbon balance derived fuel/air ratio is determined by using gas sample data to determine the carbon balance of the exhaust gases.

#### d. Total Pressure Loss

The total pressure loss ( $\Delta P_t/P_t$ ) is calculated from the following equation:

$$(6) \quad \frac{\Delta P_t}{P_t} = \frac{P_{t5} - P_{t4}}{P_{t4}}$$

where:

$P_{t5}$  = Average combustor exit total pressure

$P_{t4}$  = Average compressor discharge total pressure

#### e. Combustion Efficiency

The combustion efficiency ( $\eta_c$ ) is calculated on a deficit basis using the measured concentrations of carbon monoxide and total unburned hydrocarbons from the gas sample data. The calculation is based on the assumption that the total concentration of unburned hydrocarbons could be assigned the heating value of methane ( $\text{CH}_4$ ). The equation is:

$$(7) \quad \eta_c = 100 - 100 \left( \frac{4343X + 21500Y}{18.4 (10)^6} \right)$$

where:

X = measured carbon monoxide concentration in g/kg fuel

Y = measured total unburned hydrocarbon concentration in  $\text{gCH}_4/\text{kg fuel}$ .

## **CHAPTER III**

### **RESULTS AND DISCUSSION**

#### **A. INTRODUCTION**

The following sections discuss the emission and performance results obtained in comparative engine testing of the Federal Aviation Administration (FAA), National Aeronautics and Space Administration/Pratt & Whitney Aircraft (NASA/P&WA) exhaust emission rakes and the Station 7 instrumentation.

The data in this chapter has been confined to that which substantiates the major accomplishments of the program. A compilation of the detailed data obtained during the program is presented in Appendix B.

#### **B. EMISSION RESULTS**

Section B1 presents a comparison of the emission indices obtained with the FAA and the 24-point exhaust rakes. Section B2 presents the EPA parameters and the smoke results.

##### **1. Comparison of Emissions**

The comparisons were made by plotting the corrected emissions data obtained with the FAA and 24-point exhaust rakes against the corresponding corrected emission values obtained with the Station 7 probes.

Excellent agreement was obtained for oxides of nitrogen with deviations of less than 5 percent, as shown in Figure 14. However, the FAA rake consistently sampled carbon monoxide emission levels that were slightly higher than the 24-point rake values, as shown in Figure 15. The total unburned hydrocarbon emission data comparison, contained in Figure 16, appears to indicate a large amount of data scatter among the various probes. However, this scatter results in part from inaccuracies associated with measurement of the very small concentrations of unburned hydrocarbons produced by the Vorbix combustor.

ORIGINAL PAGE IS  
OF POOR QUALITY

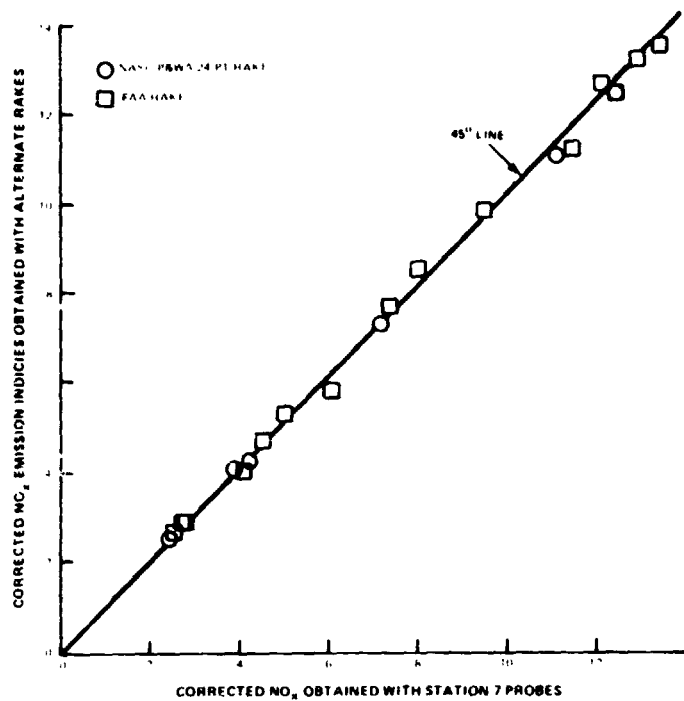


Figure 14 Relative Indications of Gas Sampling Rakes for Oxides of Nitrogen Emissions

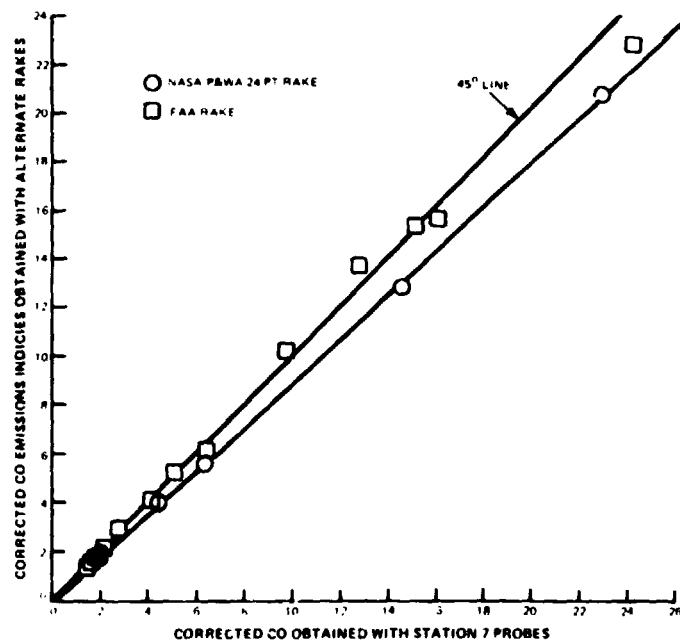


Figure 15 Relative Indications of Gas Sampling Rakes for Carbon Monoxide Emissions



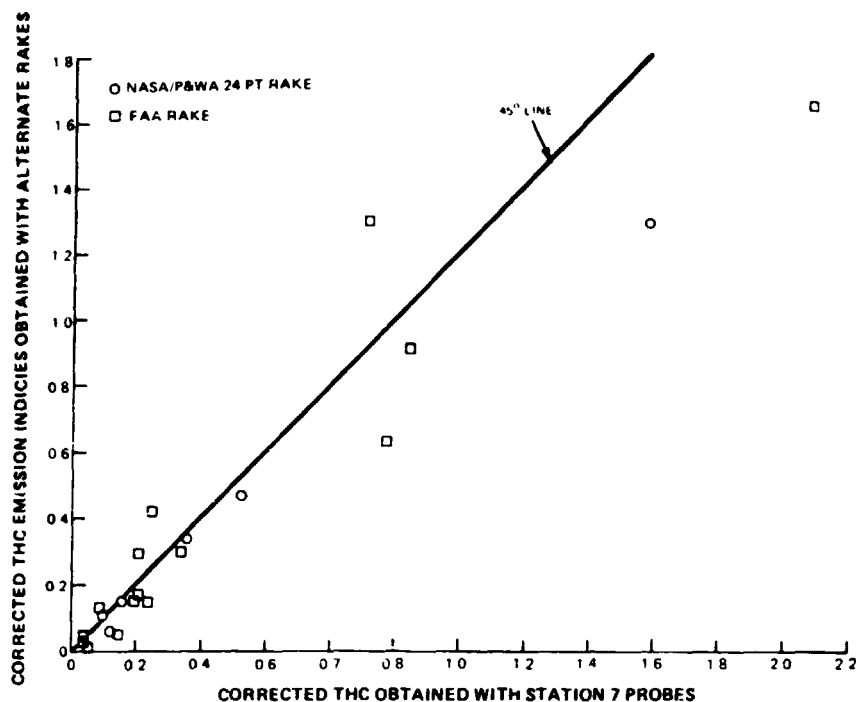


Figure 16 Relative Indications of Gas Sampling Rakes for Total Unburned Hydrocarbon Emissions

Smoke measurements, although few, produced nearly identical values with the FAA and the 24-point rakes. These data are in agreement with values obtained in the Experimental Clean Combustor Program where a maximum of 30 was recorded.

The conventional measure of gas sample validity is the comparison of the metered fuel/air ratio based on direct measurement of engine fuel flow and core airflow with the calculated fuel/air ratio based on carbon balance of the exhaust gas specie concentration detected by the sampling probe. Data for the comparison is presented in Figure 17. The FAA rake produced carbon balance fuel/air ratios that were approximately 11 percent higher than the metered fuel/air ratios at the idle and approach conditions. All other fuel/air ratios exceeded the metered values by approximately 5 percent which is consistent with the results obtained during the Experimental Clean Combustor Program.

This difference between high and low power results did not exist with the 24-point sampling rake. This suggests that sampling from a nearly single radial position, as is done with the FAA rake, produces an average exhaust sample that is sensitive to exhaust emission radial profile. Although selective radial sampling to define the radial exhaust emission profile was not conducted during this program, the severity of the change in profile between high and low power can be seen from the combustor exit radial temperature profiles presented in Figure 18. These profiles were obtained during Phase III of the Experimental Clean Combustor Program [Ref. 1], and show that single-stage pilot only operation at idle produces a temperature profile peaked toward the ID. This behavior may also explain the higher carbon monoxide emissions obtained with the FAA rake at idle and approach power.

ORIGINAL PAGE IS  
OF POOR QUALITY

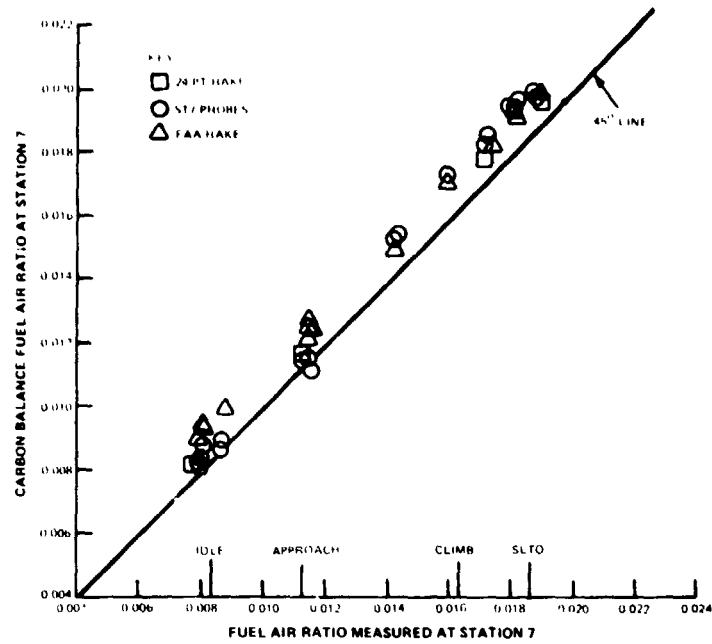


Figure 17 Comparison of Fuel/Air Ratios Determined By Carbon Balance Method From Various Gas Sampling Probes and By Direct Measurement of Fuel Flow and Airflow

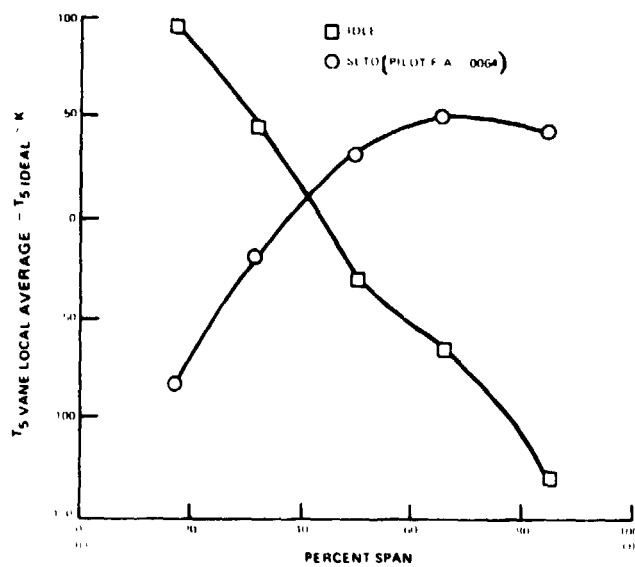


Figure 18 Exit Radial Temperature Profile for the Vorbix Combustor at Idle and Sea Level Takeoff Conditions

The EPA parameters were calculated for the Vorbix combustor from data obtained from Station 7, FAA and 24-point sampling rakes. The initial step in determining EPA parameters was to establish emission indices versus combustor inlet temperature curves presented in Figures 19, 20 and 21. Using these curves emission indices at the four EPA power settings were determined.

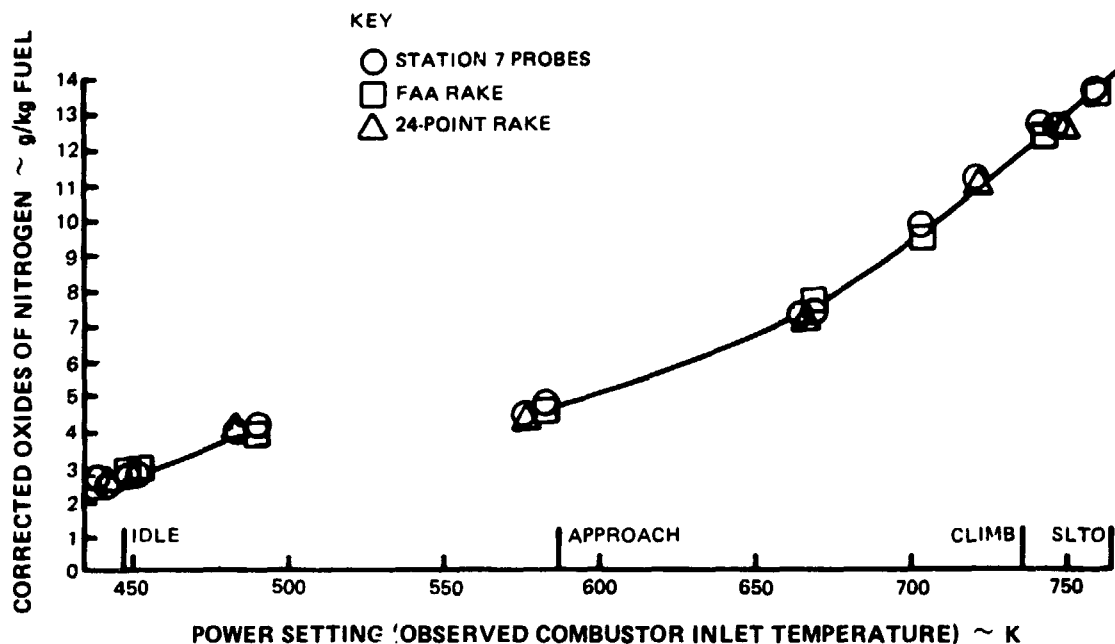


Figure 19 Corrected Oxides of Nitrogen Emissions for the Vorbix Combustor Obtained With Different Sampling Systems

The EPA parameters computed in this manner and SAE smoke numbers for the three rakes are presented in Table V. As shown, good agreement was obtained for oxides of nitrogen and total unburned hydrocarbon EPA parameters as well as SAE smoke numbers. The carbon monoxide EPA parameter calculated from the FAA rake and Station 7 probes emission indices were approximately 10 percent higher than the 24-point rake values as a result of the higher idle carbon monoxide emissions.

Similar results were obtained in comparative emission rake testing during the Experimental Clean Combustor Program. In addition to obtaining emissions with the 24-point rake and Station 7 probes, the program included traversing the 24-point rake in 5 degree increments over a 45 degree interval. The Station 7 probes produced CO emissions that were approximately 11 percent higher than the 24-point rake.

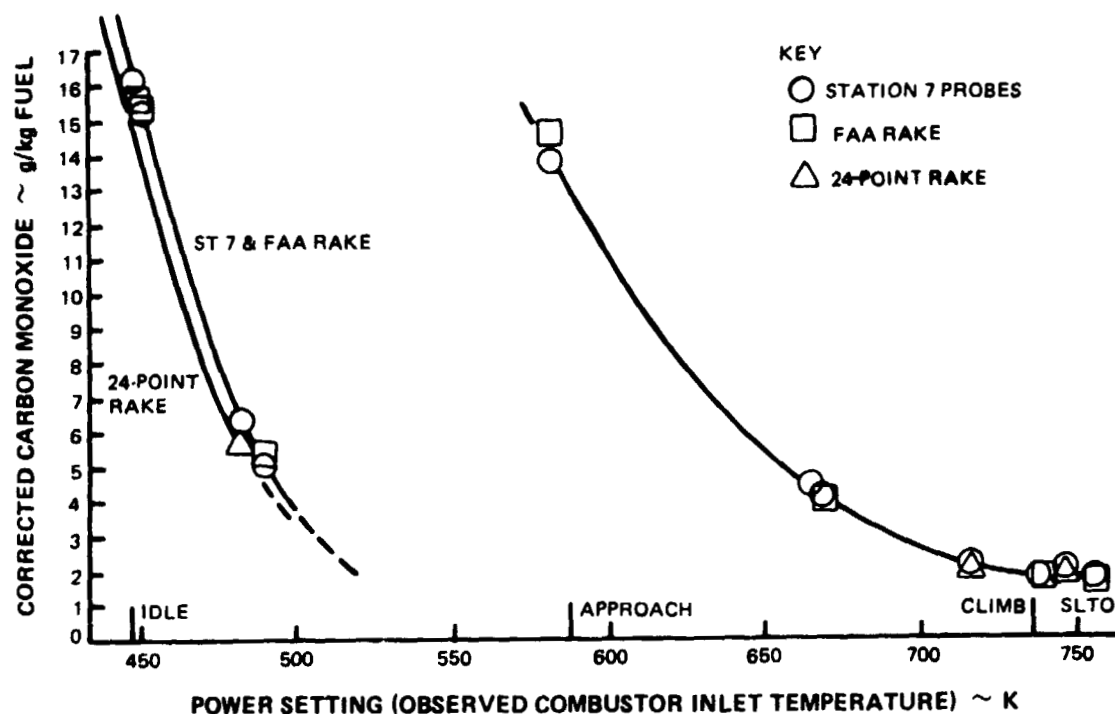


Figure 20 Corrected Carbon Monoxide Emissions for the Vorbix Combustor Obtained With Different Sampling Systems

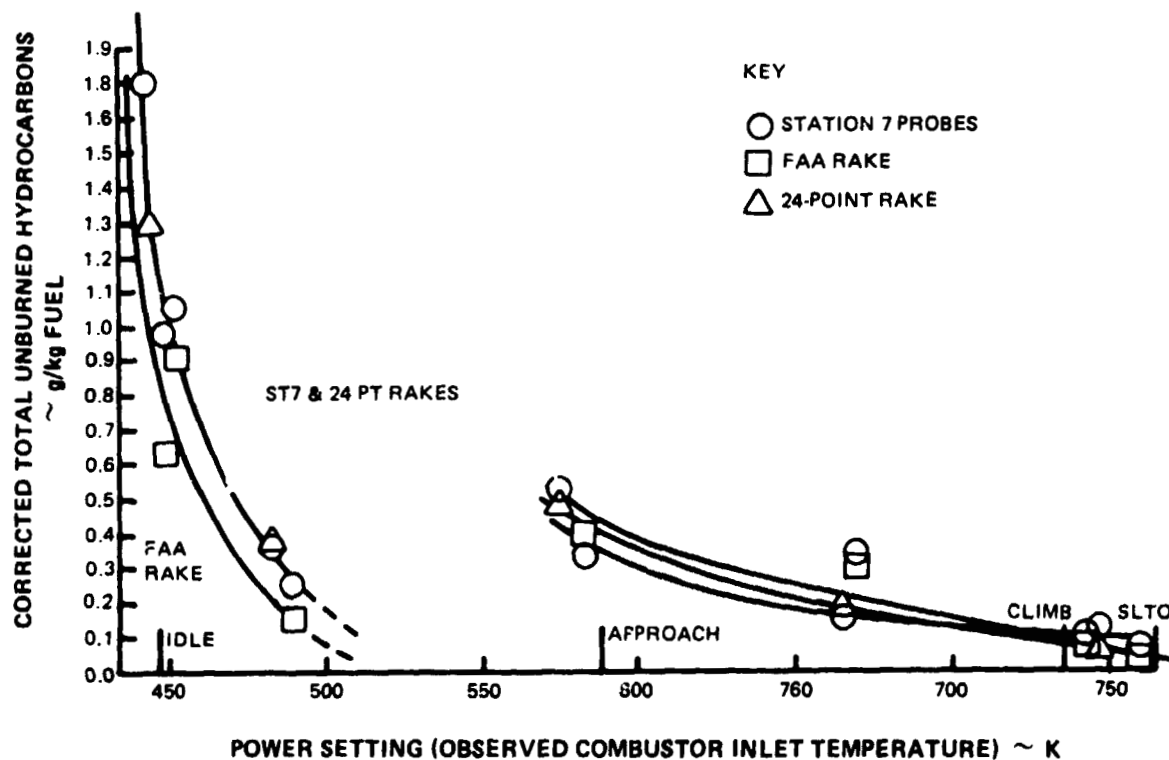


Figure 21 Corrected Total Unburned Hydrocarbon Emissions for the Vorbix Combustor Obtained With Different Sampling Systems

TABLE V  
ENVIRONMENTAL PROTECTION AGENCY PARAMETERS  
AND SMOKE RESULTS

	<u>Oxides of Nitrogen</u>	<u>Carbon Monoxide</u>	<u>Total Unburned Hydrocarbons</u>	<u>Smoke Number</u>
NASA/P&WA 24-Point Rake	2.7	3.6	0.2	31
FAA Rake	2.8	4.0	0.2	29
Station 7 Rake	2.8	4.0	0.2	Not Available

Note: All emissions data are corrected to standard JT9D-7A engine condition and inlet humidity of 6.3 gH<sub>2</sub>O/kg dry air.

### C. ENGINE PERFORMANCE

A review of the effects of the ECCP and FAA emissions rakes on engine performance indicates that the FAA rake resulted in a 1.3% reduction in effective primary area at 1.42 EPR ( $P_{t7}/P_{t2}$ ). This engine performance penalty caused by tailpipe blockage is best illustrated by Figure 22, a plot of  $P_{s4}/P_{t7}$  (expansion thru the turbine) vs. EPR ( $P_{t7}/P_{t2}$ ). This plot indicates that the ECCP rake has no measurable effect on engine match even though it has more physical blockage area than the FAA rake. This is due to the proximity of the FAA rake (7.6 cm. from tailpipe exit plane versus 35.6 cm. for the ECCP rake).

The 1.3 percent reduction in effective primary area had negligible effect on setting engine conditions and did not impact emission measurements.

ORIGINAL PAGE IS  
OF POOR QUALITY

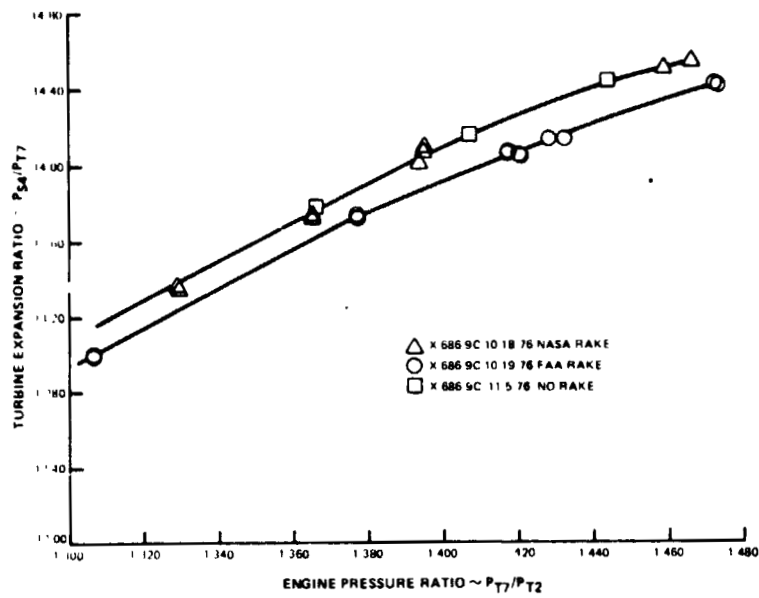


Figure 22 Affect of Sampling Rake on Engine Performance

## CONCLUDING REMARKS

Based on the results of two engine emissions tests conducted with two different sampling rakes, the principal conclusions derived from this work are:

1. The CO, THC, NO<sub>x</sub> and smoke data obtained from the FAA diamond and NASA/PWA rakes agree well at high power.
2. At low power levels (idle and approach) the CO emissions measured by the FAA rake, and Station 7 probes were approximately 10 percent higher than that measured by the NASA/PWA rake.
3. The FAA rake design evaluated in this program causes measurable tailpipe blockage and consequent engine performance shifts.

The performance shifts had negligible affect on setting engine conditions and did not impact emission measurements.

## APPENDIX A

### EQUIPMENT AND EXPERIMENTAL PROCEDURES

#### 1. EXPERIMENTAL ENGINE PERFORMANCE INSTRUMENTATION

##### A. PARAMETERS MEASURED

Table A-1 list the engine parameters measured and indicated measurement accuracy using fixed engine and test stand instrumentation.

TABLE A-1

##### PARAMETERS MEASURED

<u>Parameter</u>	<u>Measurement Accuracy</u>
$T_{T2}$ - Engine Inlet Temperature	$\pm 0.56\text{K}$ ( $1^\circ\text{F}$ )
Gearbox Breather Pressure	$\pm 34.47 \text{ N/m}^2$ (0.005 psi)
Gearbox Breather Temperature	$\pm 1.1\text{K}$ ( $2^\circ\text{F}$ )
$N_1$ - Low Rotor Speed	$\pm 0.1\%$
$N_2$ - High Rotor Speed	$\pm 0.1\%$
$F_N$ - Engine Thrust	$\pm 0.5\%$ above 111,200 N (25,000 lb) $\pm 1.5\%$ below 111,200 N (25,000 lb)
$P_{T2}$ - Engine Inlet Total Pressure	$\pm 137.90 \text{ N/m}^2$ (0.02 psi)
$P_{T2.5}$ - Fan Discharge Total Pressure	$\pm 344.74 \text{ N/m}^2$ (0.05 psi)
$P_{T7}$ - Engine Exit Total Pressure	$\pm 137.90 \text{ N/m}^2$ (0.02 psi)
$T_{T6}$ - High Turbine Discharge Temperature	$\pm 3.89\text{K}$ ( $7^\circ\text{F}$ )
$T_{T7}$ - Engine Exit Total Temperature	$\pm 2.78\text{K}$ ( $5^\circ\text{F}$ )
$P_{S4}$ - Burner Pressure	$\pm 10342.13 \text{ N/m}^2$ (1.5 psi)
$W_f$ - Total Engine Fuel Flow	$\pm 0.75\%$

These data are used to compute overall engine performance characteristics. The pilot and main fuel flows and a redundant measurement of total fuel flow are obtained from the bread-board electronic fuel control instrumentation. Redundant measurement of other selected engine parameters was also possible using the fuel control instrumentation.

##### B. ENGINE PERFORMANCE DATA CORRECTION

The observed engine performance data are corrected as follows:



- Corrected Observed Thrust

$$\frac{F_{N \text{ OBS}}}{\delta_{t2}} = \frac{\text{Observed Thrust}}{\delta_{t2}}$$

- Corrected Net Thrust

$$\frac{F_N}{\delta_{t2}} = \frac{F_{N \text{ OBS}}}{\delta_{t2}} + \frac{\Delta F_N}{\delta_{t2}} \text{ corr}$$

$$\text{where } \delta_{t2} = \frac{\text{Observed inlet pressure}}{\text{Standard day inlet pressure}}$$

$$\frac{\Delta F_N}{\delta_{t2}} = \text{Correction from Figure A-1}$$

- Corrected Fuel Flow

$$W_{f \text{ corr}} = \frac{W_f \text{ observed}}{\delta_{t2} + K_C (\text{temperature correction}) \times K_h (\text{humidity correction})}$$

- Corrected Thrust Specific Fuel Consumption

$$\text{TSFC}_{\text{corrected}} = \frac{\text{Corrected Fuel Flow}}{\text{Corrected Net Thrust}}$$

- Corrected Rotor Speed

$$N_{\text{corrected}} = \frac{\text{Observed Rotor Speed}}{\sqrt{\theta_{t2}}}$$

$$\text{where } \theta_{t2} = \frac{\text{Observed inlet temperature}}{\text{Standard day temperature}}$$

### C. DIFFUSER/COMBUSTOR INSTRUMENTATION

Pressure and temperature instrumentation installed on the Vorbix combustor liners and diffuser case passages is summarized in Figure A-2. Typical total pressure and temperature probes installed at the compressor discharge plane (Station 4.0) are shown in Figure A-3.

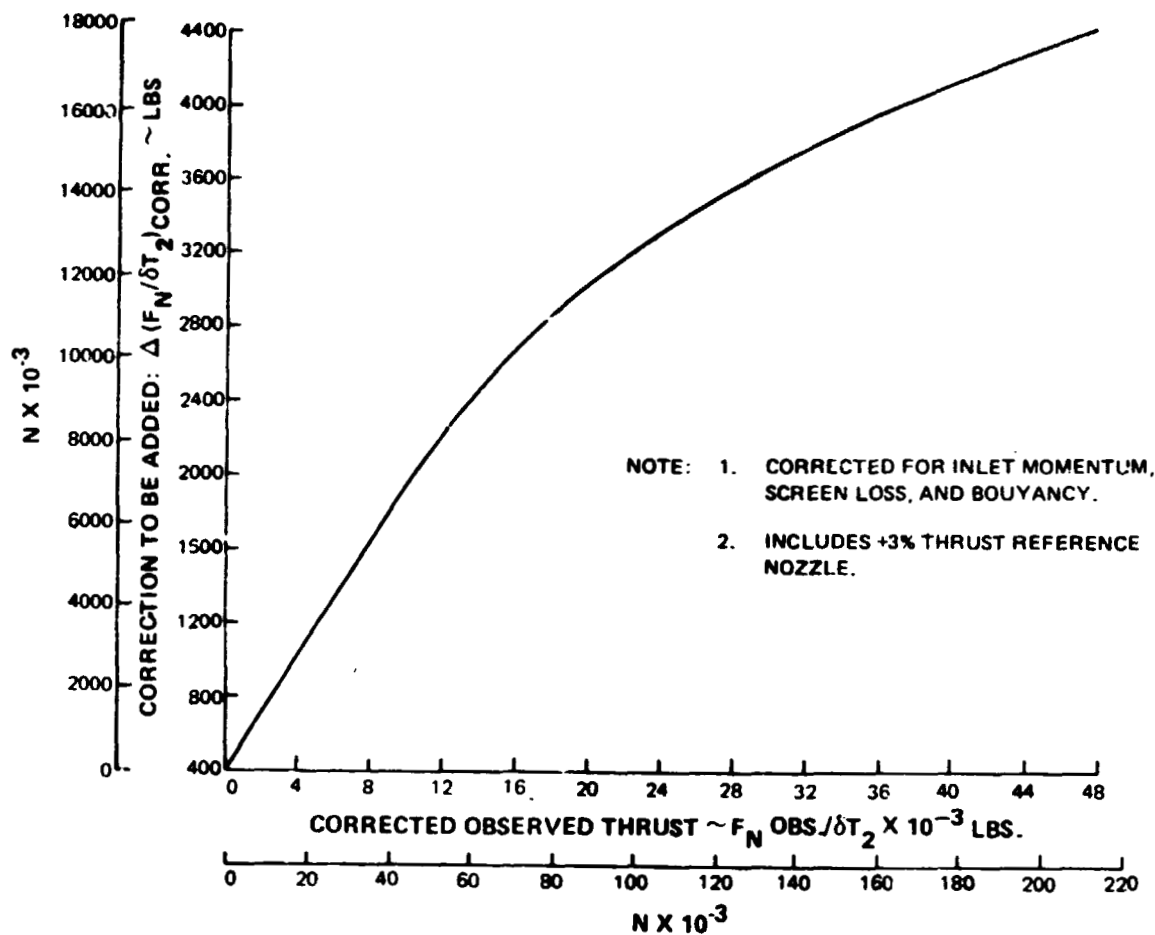


Figure A-1 JT9D Turbofan Engine Test Cell Thrust Correction for Middletown Test Cells

ORIGINAL PAGE IS  
OF POOR QUALITY



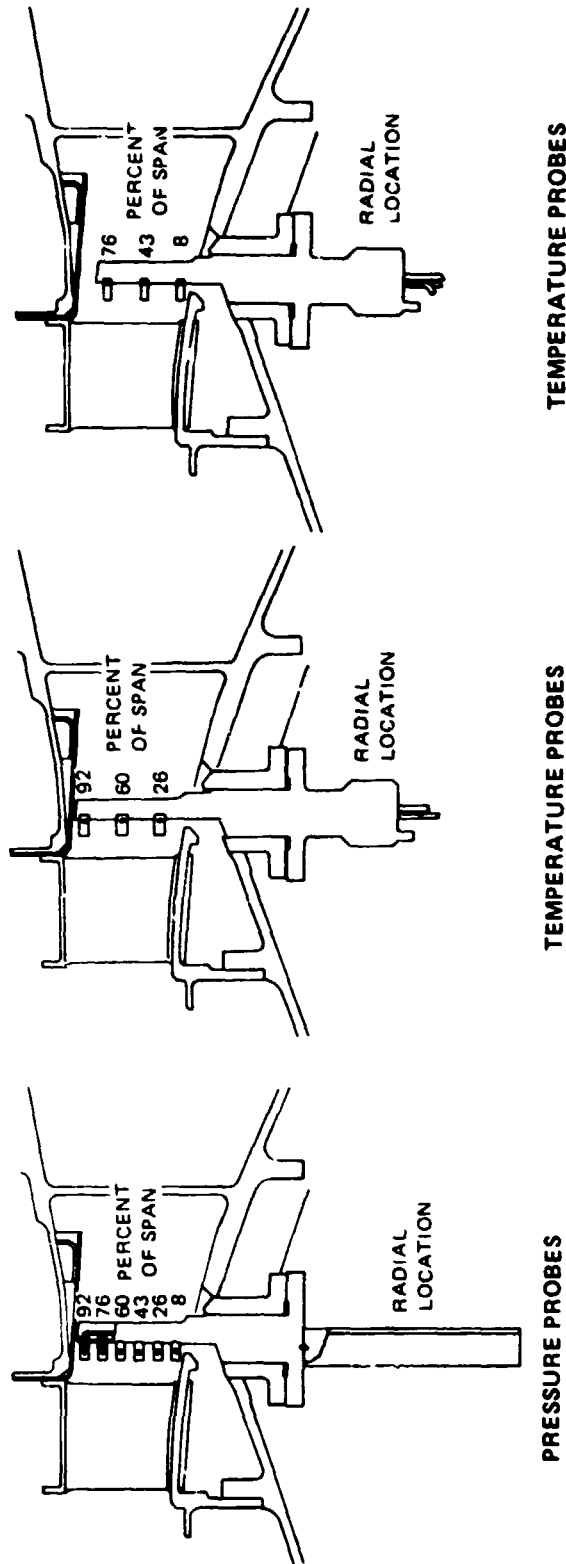
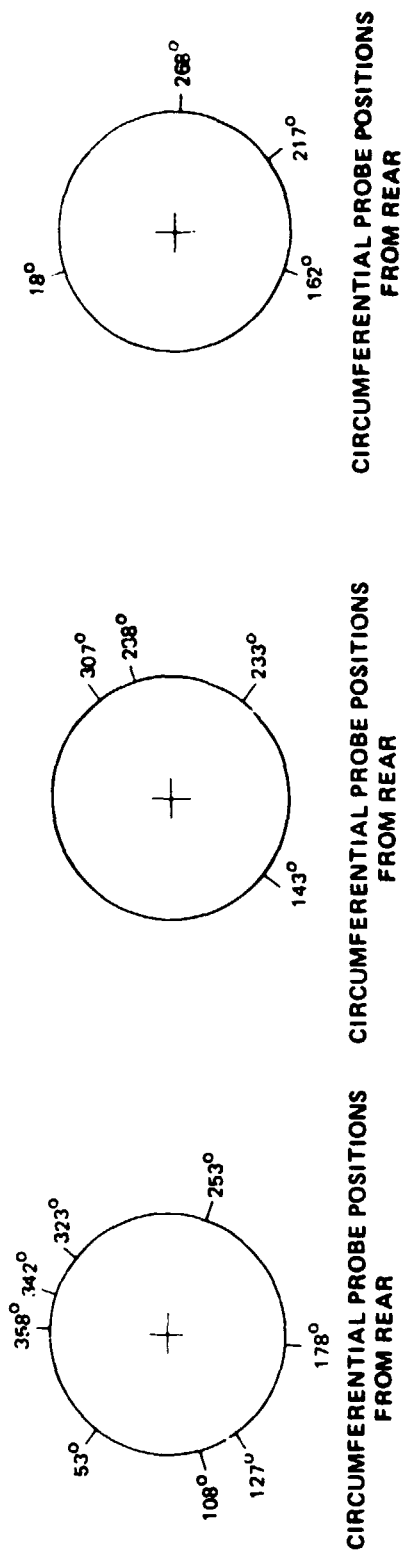


Figure A-3 Station 4 Radial and Circumferential Total Pressure and Total Temperature Probe Locations

ORIGINAL PAGE IS  
OF POOR QUALITY

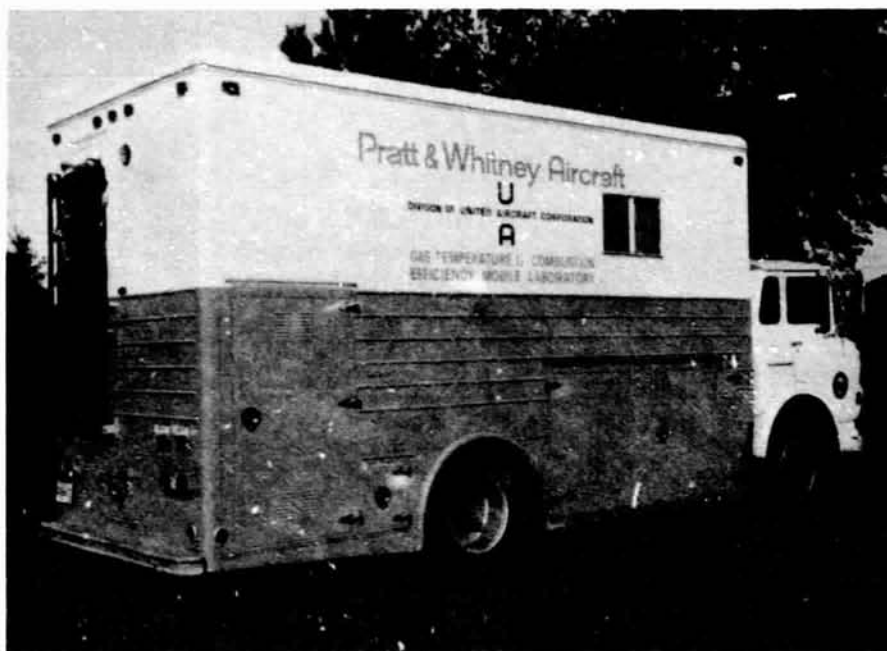
## 2. GAS SAMPLING AND ANALYSIS EQUIPMENT

### A. MOBILE GAS ANALYSIS LABORATORY

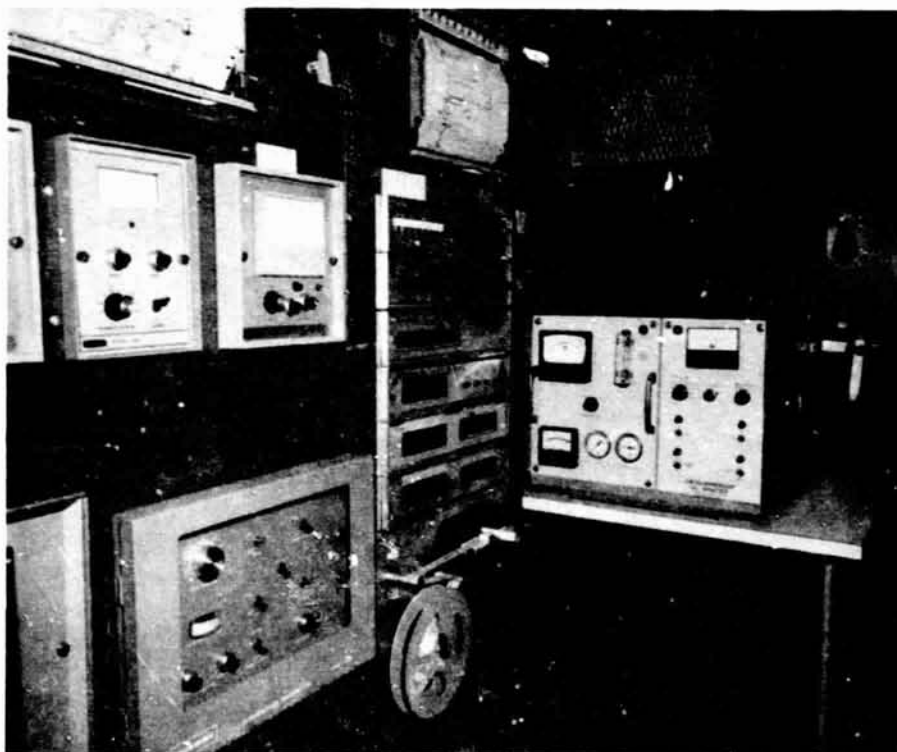
The Pratt & Whitney Aircraft gas temperature and combustion efficiency (GT&CE) mobile laboratory (Figure A-4) is a specially designed vehicle capable of measuring gaseous combustion exhaust products. Through the use of a telephone link to the centralized Sigma 8 data reduction computer system, measured constituent concentrations can be converted to real time, on-line computations of emission index, combustion efficiency, and combustion exit temperature. The results of these computer calculations, together with the raw data, the measurement uncertainties, and data validity checks are displayed on an interactive scope in the GT&CE mobile laboratory. The GT&CE mobile laboratory is completely self-contained with the exception of the data reduction computer, and incorporates the latest on-line gas analysis instrument for the measurement of carbon dioxide, carbon monoxide, nitrogen, oxygen, hydrogen, oxides of nitrogen, total unburned hydrocarbon, and water vapor. An interior view of the mobile van is shown in Figure A-5. Individual analyzer specifications are summarized in Table A-II.

The GT&CE mobile laboratory utilizes a heated stainless steel metal bellows sample pump to draw a sample of the jet engine combustion products into the sample measurement train. Another larger vacuum-type bypass pump is also incorporated into the sampling system to minimize the residence time of the sample in the sample line. The engine exhaust gas sample is distributed to the various instruments, with each instrument having its own flow metering system. The sample handling system is shown schematically in Figure A-6. The outputs from these instruments are recorded and monitored continuously on strip chart recorders. The analyzer outputs are also digitized and, on command, are sent via a telephone line to a Sigma 8 computer and/or recorded on a cassette-type magnetic tape recording system. The magnetic tape is compatible with the IBM-360 computer which is used for off-line special data reduction and validation programs.

Each instrument is provided with "sample" and "calibration" operating modes. The GT&CE mobile laboratory carries its own calibration, zero and span gases. In support of this mobile laboratory, an in-house analytical laboratory develops calibration gases and maintains standard reference gases which, in most cases, are traceable to the National Bureau of Standards (NBS).



*Figure A-4*      *Mobile Laboratory for Measurement of Gaseous Combustion Exhaust Products*    (CN-40146)



*Figure A-5*      *On-Line Gas Analysis Equipment*    (CN-40168)

TABLE A-II  
ANALYZER SPECIFICATIONS

Component	Range	Direction Method	Minimum Detectability	Error % Full Scale
O <sub>2</sub>	0-10% V 0-25% V	Amperometric	0.25% V	± 1.0%
N <sub>2</sub>	0-90%	Gas Chromatograph	0.1% V	—
H <sub>2</sub>	0-1% 0-5%	Gas Chromatograph	0.1% V	—
O <sub>2</sub>	0-25%	Gas Chromatograph	0.1% V	—
CO	0-100 ppmv 0-500 ppmv 0-2500 ppmv 0-2500 ppmv	NDIR	2 ppmv	± 2.0% ± 1.0% ± 1.0% ± 1.0%
CO <sub>2</sub>	0-2% V 0-5% V	NDIR	0.04% V 0.25% V	± 1.0% ± 1.0%
THC (As Methane)	0-1 ppmv Through 0-50K ppmv	FID	0.1 ppmv	± 5.0% ± 1.0%
NO <sub>x</sub>	0-2.5, 0-10-6.25, 0-100 0-250 - 0 - 1000 0-2500 0-10000	CL	0.1 ppmv	± 0.5%
H <sub>2</sub> O	-45°C - +60°C	CMHY	0.06°C	± 0.4°C
CL - Chemiluminescence		NDIR - Non-Dispersive Infrared	NDUV - Non-Dispersive Ultraviolet	
FID - Flame Ionization Detector		CMHY - Chilled Mirror Hygrometer		

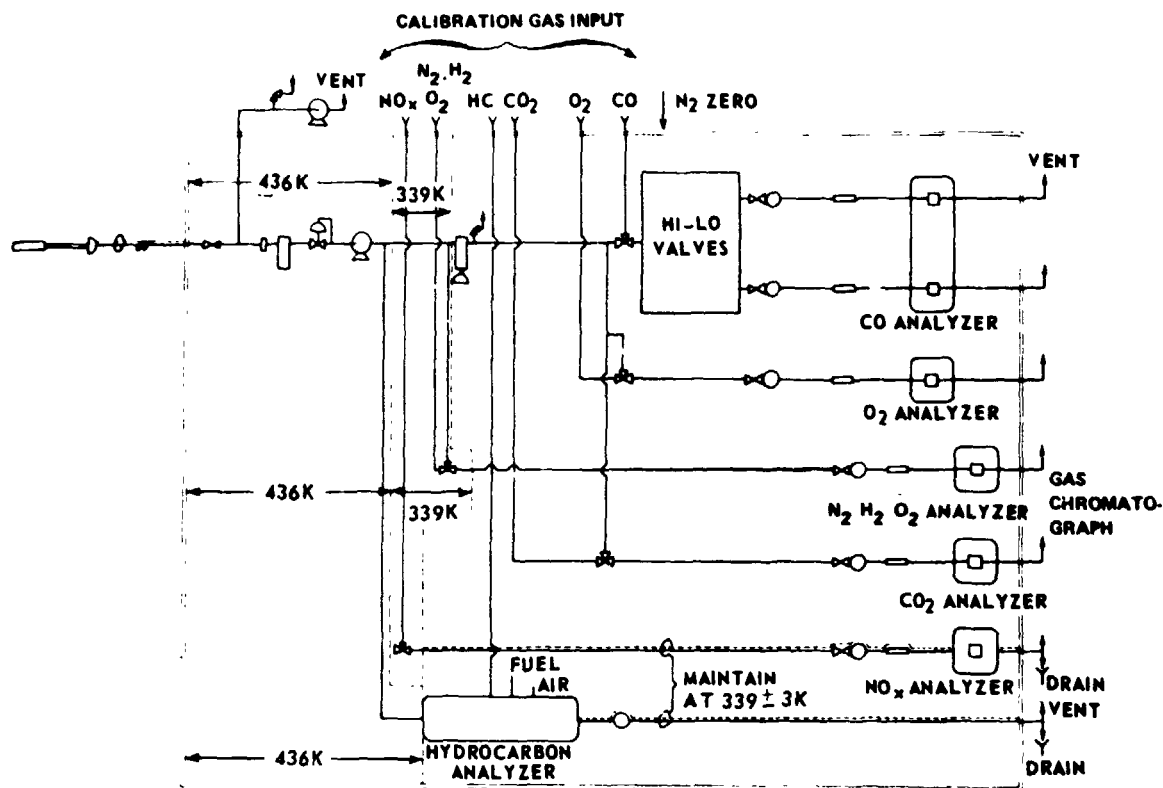


Figure A-6 Exhaust Gas Sample Handling System

## B. SMOKE MEASUREMENT CONSOLE

Engine exhaust smoke measurements were obtained using a smoke measuring system that conforms to specifications of the Society of Automotive Engineers Aerospace Recommended Practice 1179 and the Environmental Protection Agency [Reference 1].

The smoke measuring console, shown in Figure A-7, is a semiautomatic electromechanical device which incorporates a number of features to permit the recording of smoke data with precision and relative ease of operation. The smoke console was installed in the engine test cell control room for the duration of the test program. Dimensions of the filter holder and a schematic of the sampling system are shown in Figure A-8. The filter holder has been constructed with a 2.54 cm (1.0 inch) diameter spot size, a diffusion angle  $\theta$  of 7.25 degrees and a converging angle  $\alpha$  of 27.5 degrees.

ORIGINAL PAGE 1.  
OF POOR QUALITY



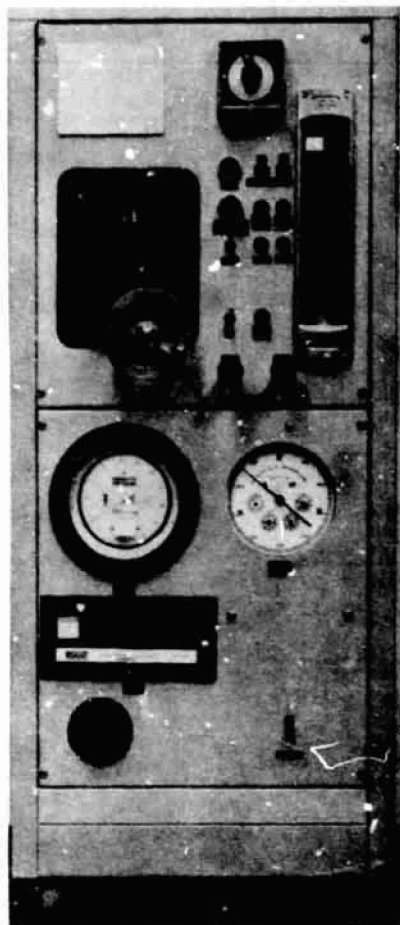
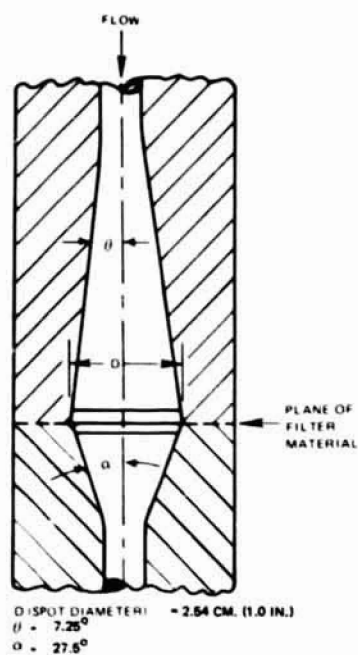
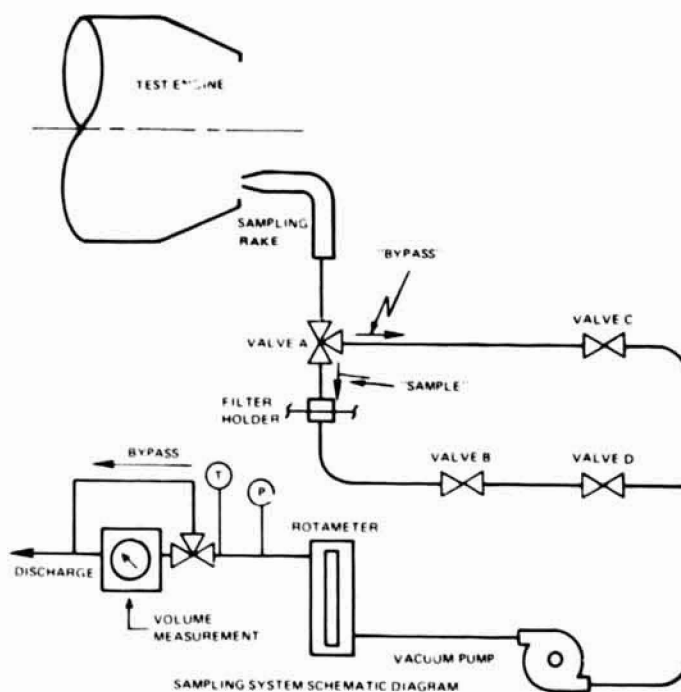


Figure A-7 SAE/EPA Smoke Meter  
(CN-47639)



FILTER HOLDER SCHEMATIC DIAGRAM



SAMPLING SYSTEM SCHEMATIC DIAGRAM

Figure A-8 Details of SAE/EPA Smoke Meter Construction

The unit is designed to minimize variability resulting from operator to operator differences. One of these features is a time controlled, solenoid activated main sampling valve (Valve A. See Figure A-10) having "closed", "sample", and "bypass" positions. This configuration permits close control of the sample size over relatively short sample times. In addition, this timing system operates a bypass system around a positive displacement volume measurement meter to ensure that the meter is in the circuit only when a sample is being collected or during the leak check mode. Other design features include automatic temperature control for the sample line and filter holder, and silicon rubber filter holders with support screens for ease of filter handling.

A Photovolt Model 670 reflection meter with a type-Y search unit conforming to ASA Ph 2.17-1958 "Standard for Diffuser Reflection Density" is used to determine the reflectance of clean and stained filters. A set of Hunter Laboratory reflectance plaques, traceable to the National Bureau of Standards, is used to calibrate the reflectance meter. A computer program is used to calculate the gas sample weight per unit filter area and smoke number.

ORIGINAL PAGE IS  
OF POOR QUALITY

### **3. P-6 TEST FACILITY**

#### **A. FACILITY DESCRIPTION**

The P-6 test stand, one of eight ambient-inlet indoor test cells located at the Pratt & Whitney Aircraft production facility in Middletown, Connecticut, has been fitted with the additional instrumentation and data handling capability required for automatic temperature recording system (ARTS) and low-emission combustor development programs. The facility is equipped with a monorail engine handling system to facilitate movement of the engine into and out of the test cell. A schematic view of the test cell layout is shown in Figure A-9. Figure A-10 shows a front view of a JT9D engine with inlet bellmouth and screen mounted in the test cell. All engine controls, data logging, and computer face equipment are located in the test cell control room. A view of the control console is shown in Figure A-11. The breadboard fuel control computer and peripheral equipment were also installed in the test stand control room. The mobile emissions laboratory was parked outside and to the rear of the test cell while testing was in progress.

A multiple quick disconnect Instrumentation Connection Assembly (ICA) has been incorporated into the facility to reduce the connection time when installing an engine into the test cell. Half of the ICA unit stays in the cell and remains connected to the test stand data acquisition and readout system. The other half is installed on the engine mount frame and instrument lines are connected to the engine during the preparation operation in the marshaling area outside the cell.

A flight-type nacelle is not normally employed for either experimental or production JT9D engine testing. A cylindrical core engine exhaust nozzle is used in place of the plug-type flight design. A pair of bifurcated fan ducts are used in place of the annular fan duct. The fan and core nozzle areas are sized to provide aerodynamic characteristics equivalent to the flight nacelles. The bifurcated fan ducts facilitate installation of special instrumentation and test hardware, and are readily removed for access to the core engine.

Figure A-12 shows the X-686 engine being moved into the test cell on the monorail carrier for a fuel system leak check prior to starting the Phase III Vorbix combustor test program. The leak check is conducted at engine idle power with the fan ducts off. Details of the engine mounting frame, quick-disconnect instrumentation couplings, and cylindrical core engine tailpipe are visible. The engine is shown with the bifurcated fan ducts installed in Figure A-13.

#### **B. DATA ACQUISITION SYSTEMS**

The P-6 engine test stand is equipped with two separate and complete data systems. All basic engine performance parameters are determined using the Automatic Production Test Data Acquisition and Control System (APTDAC) which is available to all production test cells. The 2104 Data Acquisition System (ADAPTS) was designed to support ARTS combustor development programs, and is available only in the P-6 test stand at the Middletown Test Facility.

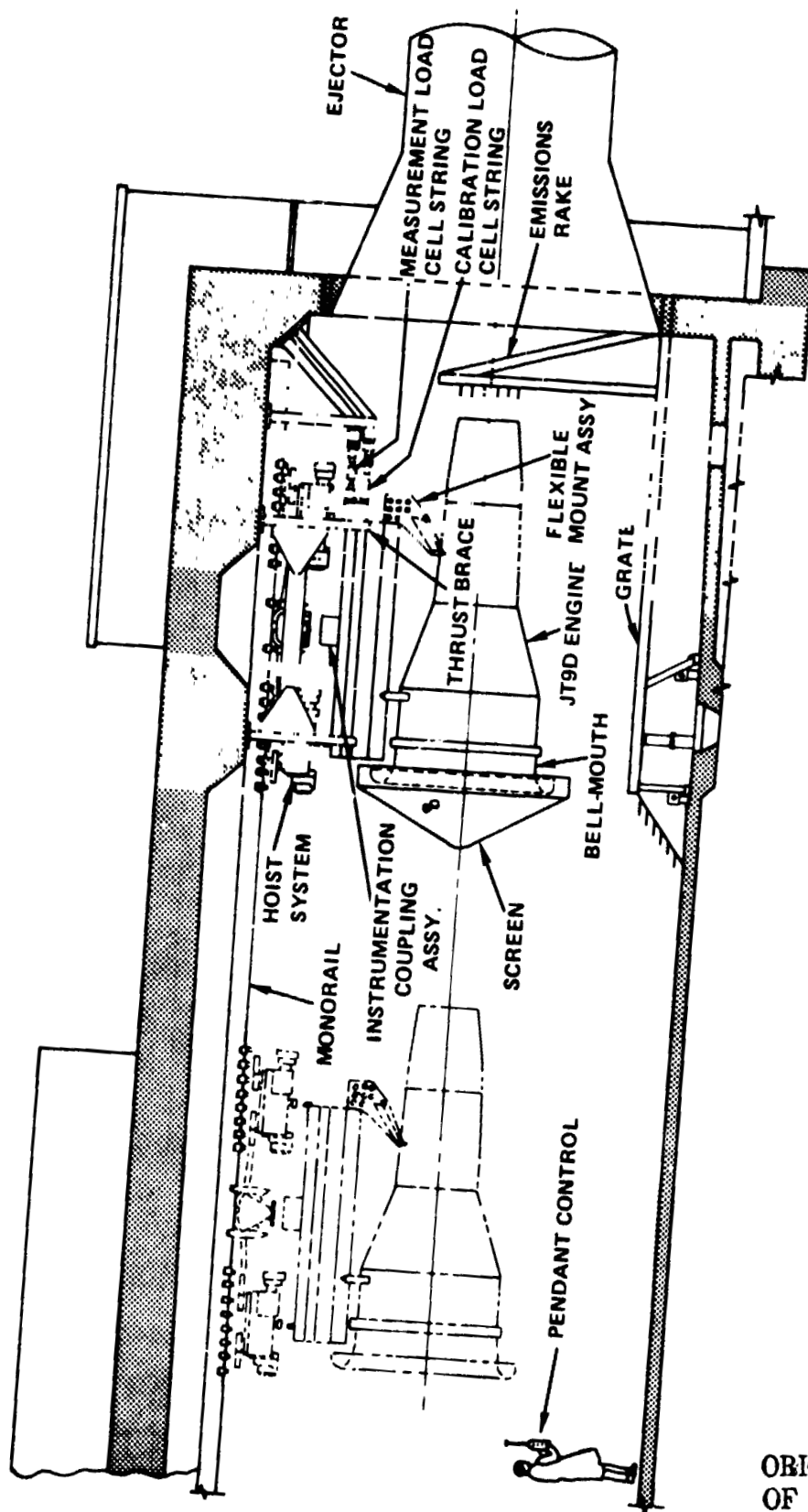
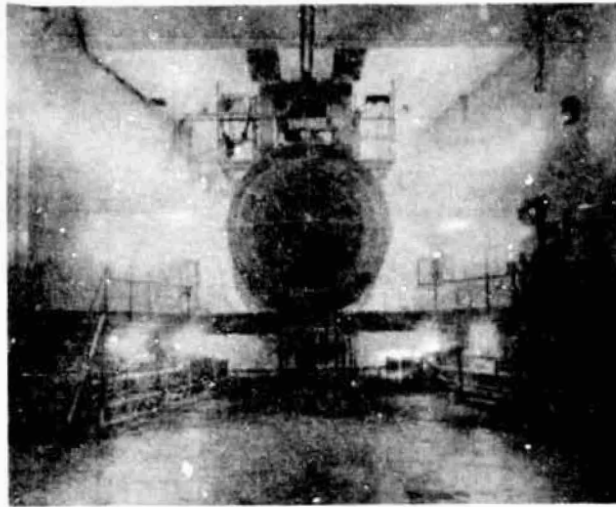
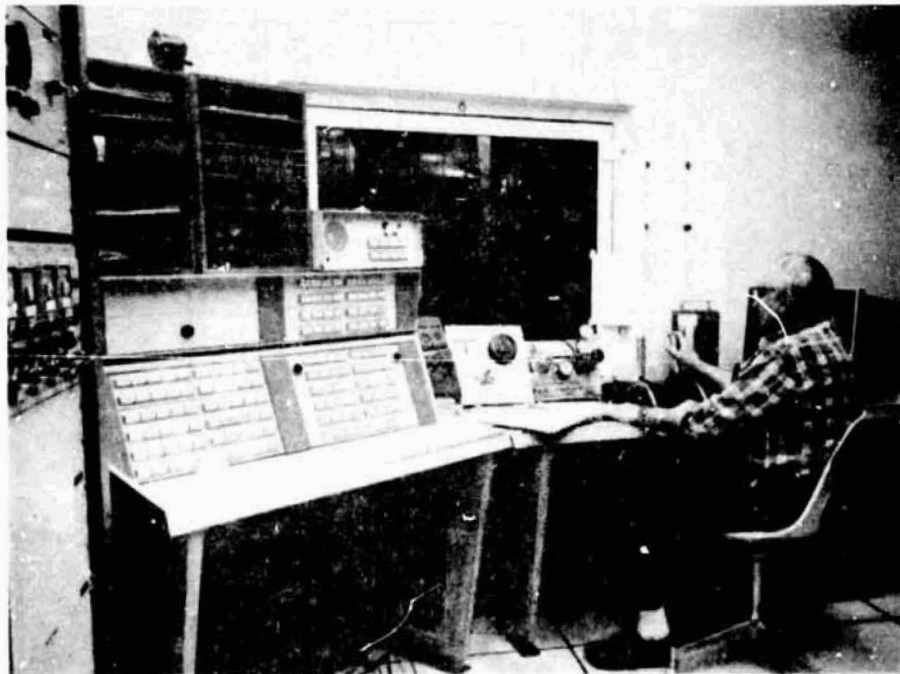


Figure A-9 P-6 Test Cell Layout

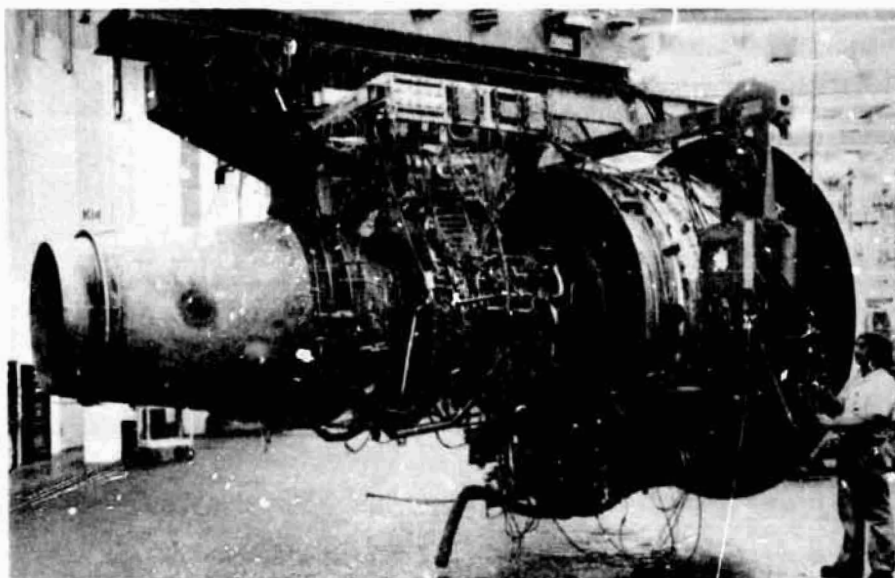
ORIGINAL PAGE IS  
OF POOR QUALITY



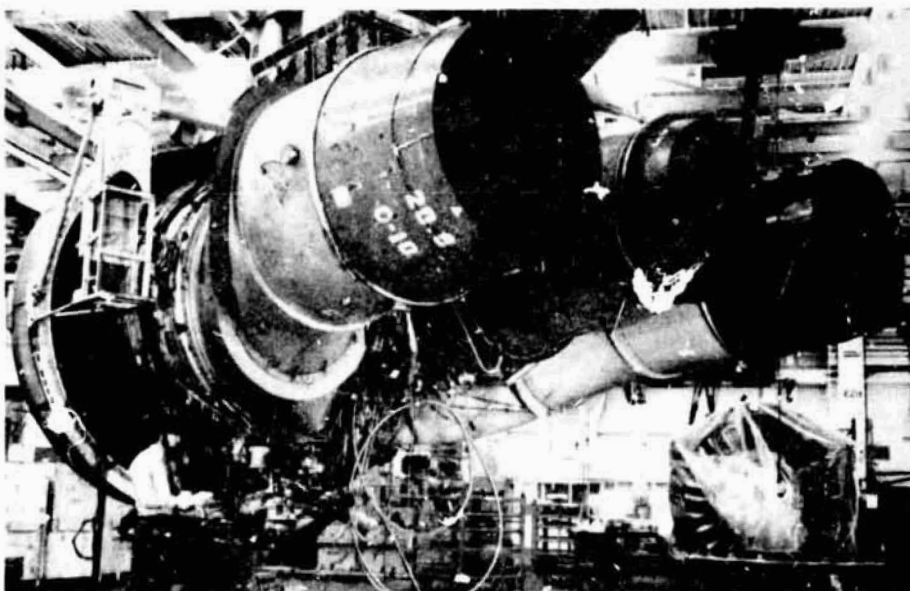
*Figure A-10 JT9D Engine Mounted in Production Test Cell Showing Inlet Bellmouth and Screen*



*Figure A-11 Control Console in P-6 Test Stand Used in Phase III X-686 Engine Tests (76-441-4072-H)*



*Figure A-12 Right Side View of X-686 Being Moved Into the Test Cell for the Initial Ducts Off Leak Check (CN-57544)*



*Figure A-13 Experimental Engine, X-686, With Bifurcated Ducts Installed (X-43208)*

ORIGINAL PAGE IS  
OF POOR QUALITY

All aspects of engine performance evaluation — instrumentation hookup, calibration, data logging, performance analysis, data display, and control — have been streamlined by the APTDAC System. APTDAC is an integrated system of sensors, signal conditioning equipment, engine control consoles, digital computers, and cathode-ray tube display devices designed to perform all operating functions automatically. Figure A-14 presents an overview of the system functions.

The APTDAC system is capable of testing eight engines simultaneously — the facility has four computers and each computer can handle two test cells. Each computer is linked to sensing devices in the engine by way of automatic data equipment. Pneumatic and electric transducers measure some 80 different engine operating parameters and relay quantitative data to the computer.

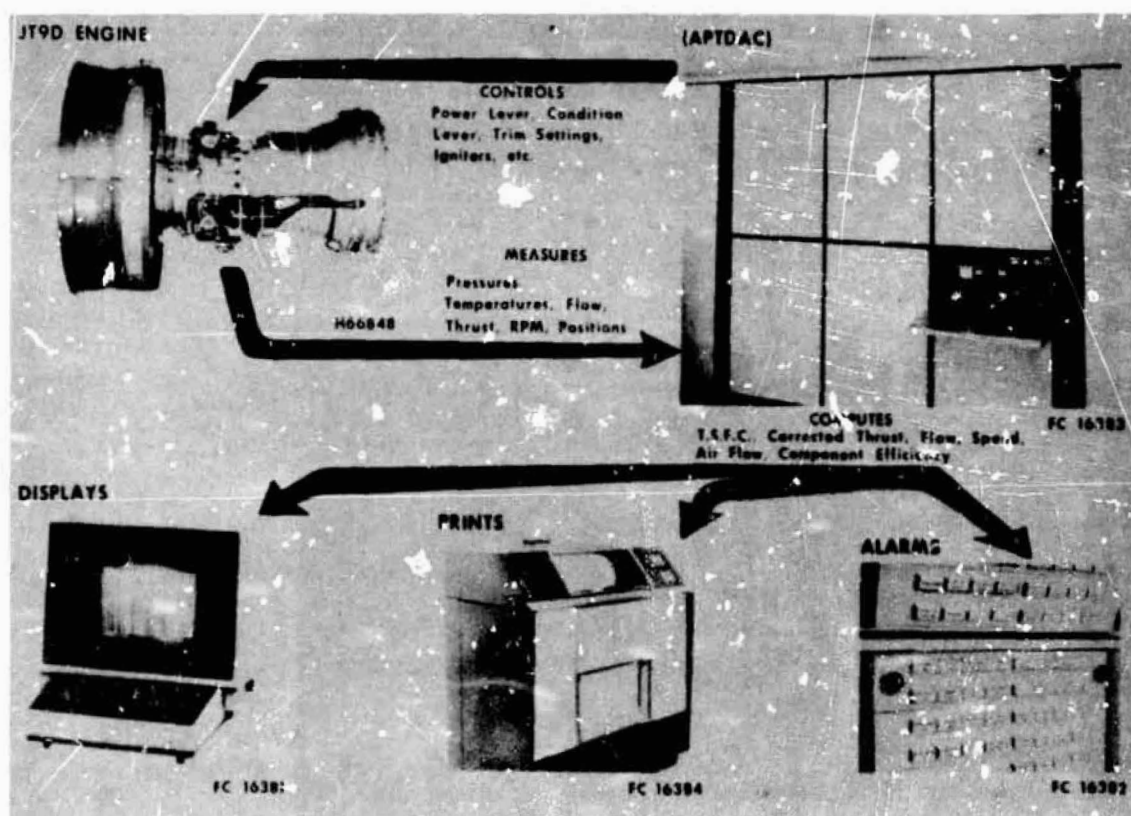


Figure A-14 Automatic Production Test Data Acquisition and Control System Functions



Whether measuring the operating conditions of one or two engines, the assigned APTDAC system computer performs the following acquisition, analysis, and recording tasks:

- Converts the transducer output signals to engineering units
- Corrects the data to standard conditions
- Computes the performance data needed to determine compliance with engine specifications
- Compares selected parameters against established limits and activates an alarm if limits are exceeded
- Displays the data to the operator on a cathode-ray tube
- Provides print-out of the acquired and computed data, on command.

Figure A-15 depicts the flow of data in the system. The APTDAC system is able to scan each variable 10 times, average readings, compute complete engine performance, and print out the results within 15 seconds.

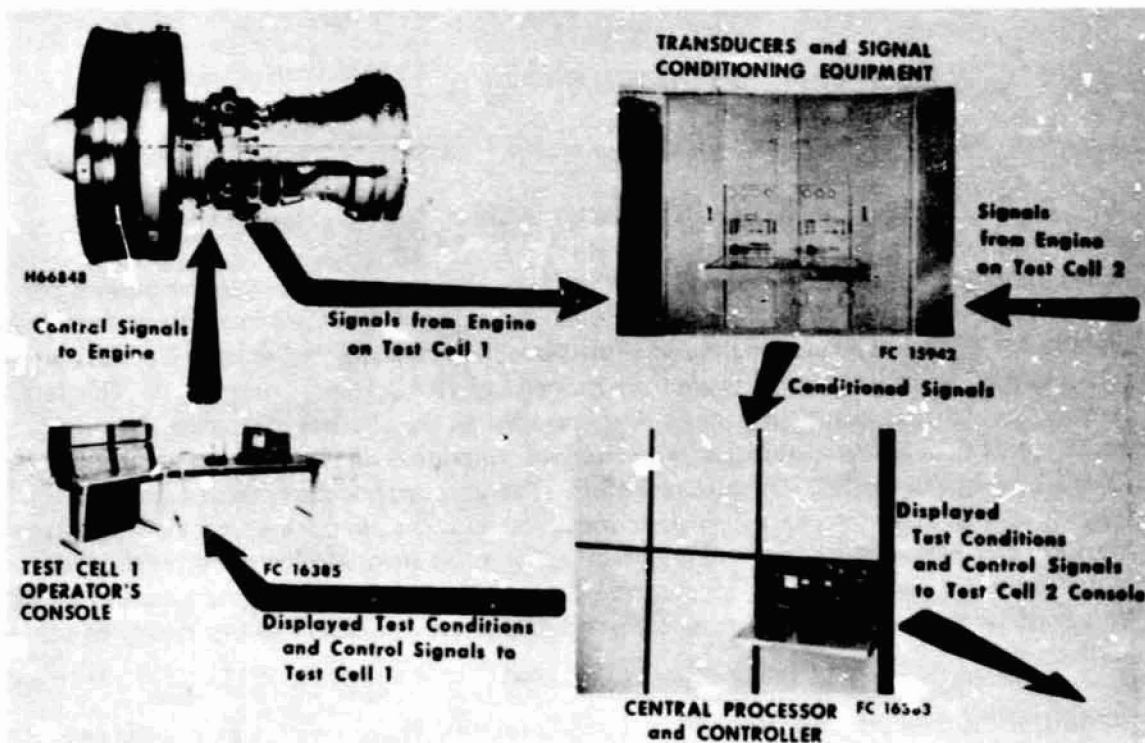


Figure A-15 Automatic Production Test Data Acquisition and Control System Data Flow

ORIGINAL PAGE IS  
OF POOR QUALITY



Major features built into the computerized engine test system include the capability to conduct tests in either automatic or operator mode, a dynamic update system which allows program changes while running, a debug package, capability for aborting an engine run while in automatic mode when harmful conditions are sensed, and an error message which indicates possibly invalid data.

The 2104 ADAPTS system has the capacity to record up to 1000 millivolt inputs and 384 pressure inputs on five 200 channel scanners and eight 48 port scanning valves. Up to 400 Type B, 500 Type S, and 60 Type K thermocouples, plus two engine speeds, two fuel flows, and 360 pressure parameters can be recorded for any given engine. The remainder of the inputs are used as confidence and reference channels to monitor system accuracy.

The data system has been designed with quick disconnect pressure fittings and electrical connectors to enhance the quick mount capability of the test stand. This provision allows the engine to be installed and connected to the data system in less than two hours. Special features of the data recording system include:

- Channel delete capability
- Three wire guarded system
- OHMS checking capability for thermocouple continuity
- Variable start and end point scan selection
- Manual channel monitoring

### **C. DATA REDUCTION AND LOGGING SYSTEM**

The data reduction and logging function for the basic engine performance information is performed by the APTDAC system. All other data, including ARTS thermocouple readings, combustor/diffuser pressure and temperature measurements, and engine emissions data are processed by an on-line Sigma 8 computer located in East Hartford, Connecticut. The data acquisition units transmit the data by telephone line to the Sigma 8 computer. Approximately 45 seconds after acquisition, processed information is displayed on an alphanumeric character scope in the test stand control room. The user can select any one of several scope picture (pages) displaying data in engineering units. In addition, the user can view calculated performance parameters based on input data including air flow, Mach numbers, and ideal combustor exit temperature. This real time display of results allows precise matching of test conditions to test program parameters and immediate assessment of the quality of the data.

Editing of the data can be performed via a delete system. Hard copies of all raw data and performance parameters are available at the Sigma 8 computer room in East Hartford as the test is conducted. In addition to hard copies and scope output, the data is recorded and available in other formats.

Raw data is recorded on magnetic tape at the test stand and is available for input to an off-line data reduction computer program for additional processing. Data can be acquired on this magnetic tape unit with or without the Sigma 8 computer being on-line. At the option of the user, raw data can be printed in tabular form on a paper tape printer in the test stand control room. The user can also produce punch cards at East Hartford. All raw data received by the Sigma 8 computer is redundantly recorded on magnetic tape at East Hartford.

- In order to minimize the number of entry ports to the Sigma 8 computer occupied by P-6 test stand, special equipment has been installed at the P-6 test stand to permit the 2104 ADAPTS in the test stand control room and the data logging system in the Gas Temperature and Combustion Efficiency (GT & CE) mobile laboratory to time-share the telephone link to the Sigma 8. Priority for transmission of data remains with the 2104 ADAPTS. Upon command from an operator in the P-6 control room, a special electronic switch enables the mobile laboratory to transmit data upon completion of an 2104 ADAPTS transmission. When the Sigma 8 receives the coded signal from the mobile laboratory, it reduces the data and performs the calculations in accordance with instructions in the Mobile Laboratory for Emission Analysis (MOLE) program. The results of the calculations are transmitted back to an interactive scope in the mobile laboratory.

The mobile laboratory operator selects one of three calculation pages to be displayed: an emission data reduction page, a data validation page, and an instrument calibration page. The information displayed when the emission data reduction page is selected includes: fixed identification data, emission concentration, emission index (EI) for each constituent, measured 2 sigma variation of the emission data, carbon basis fuel/air ratio, measured fuel flow, calculated air flow, and calculated combustor exit temperature.

ORIGINAL PAGE IS  
OF POOR QUALITY

## APPENDIX B

### EMISSIONS AND PERFORMANCE DATA

The following table present the detailed emissions and performance data obtained during the program. Emissions data were obtained using three different gas sampling techniques as described in Chapter II and Appendix A. The gas sampling rakes used and their symbol designations used on the data tables are presented below:

Symbol	Description
24F	24-Port, 8-Arm, Radial Array, Fixed
ST7	Station 7 Pressure Probe With 8 Radial Pressure Taps
FAA	12-Port, 4-Arm, Diamond Shape

POINT	THRUST - N	ENGINE INLET PRESSURE - ATM	MOISTURE - % CH <sub>4</sub> /C AIR	AIRFLOW - STATION 4 M3	AIRFLOW - STATION 4 M3	TOTAL PRESSURE STATION 4 - ATM	FUEL FLOW PILOT - kg/s	FUEL FLOW MAIN - kg/s	TEMPERATURE - K	IDEAL COMBUSTION EXIT	PATTERN FACTOR	REFERENCE VEL - m/s	FUEL AIR RATIO COMBUSTION METERED	FUEL AIR RATIO PILOT	BALANCE AIR CARBON F/ACR	CO <sub>2</sub> - %	NO (EII) AS MEASURED	NO (EII) AS MEASURED	EFFICIENCY	SAE SMOKE NO	NO (EII) CORRECTED FOR HUMIDITY & PRESSURE	CO (EII) CORRECTED FOR PRESSURE	THE (EII) CORRECTED FOR PRESSURE	RAKE COMMENTS (I)	
1555	297503	0.996 276	0.0011 324	1.02	1.02	0.994	1.575	1.555	1342	1342	0.0	50	0.00237	0.0066	0.0102	1.02	2.03	1.09	1.09	1.09	1.09	1.09	1.09	1.09	0.12 STT SITO
1556	297504	0.996 276	0.0011 324	1.02	1.02	0.994	1.575	1.555	1342	1342	0.0	50	0.00237	0.0066	0.0102	1.02	2.03	1.09	1.09	1.09	1.09	1.09	1.09	1.09	0.12 STT SITO
1557	173399	0.993 277	0.0011 326	1.004	1.004	1.1	14.92	14.92	1459	1459	0.0	49	0.00217	0.0034	0.0182	1.06	3.70	1.69	1.69	1.69	1.69	1.69	1.69	1.69	0.10 STT CLIMBEN
1558	173402	0.993 277	0.0011 326	1.004	1.004	1.1	14.92	14.92	1459	1459	0.0	49	0.00217	0.0034	0.0182	1.06	3.70	1.69	1.69	1.69	1.69	1.69	1.69	1.69	0.10 STT CLIMBEN
1559	121595	0.999 277	0.0011 331	92.5	92.5	66.4	14.70	66.4	1301	1301	0.0	48	0.0162	0.0065	0.0151	1.05	3.09	3.69	3.69	3.69	3.69	3.69	3.69	3.69	0.15 STT SUELLING
1560	122191	0.999 277	0.0011 331	92.5	92.5	66.4	14.70	66.4	1301	1301	0.0	48	0.0162	0.0065	0.0151	1.05	3.09	3.69	3.69	3.69	3.69	3.69	3.69	3.69	0.15 STT SUELLING
1561	1000 580	0.999 277	0.0011 332	95.6	95.6	44.9	9.18	576	1102	1102	0.0	45	0.0143	0.0073	0.0114	1.03	3.32	3.15	3.15	3.15	3.15	3.15	3.15	3.15	0.16 STT SUELLING
1562	1000 581	0.999 277	0.0011 332	95.6	95.6	44.9	9.18	576	1102	1102	0.0	45	0.0143	0.0073	0.0114	1.03	3.32	3.15	3.15	3.15	3.15	3.15	3.15	3.15	0.16 STT SUELLING
1563	6107 1	1.004 277	0.0012 326	35.6	35.6	44.9	9.18	576	1102	1102	0.0	45	0.0143	0.0073	0.0114	1.03	3.32	3.15	3.15	3.15	3.15	3.15	3.15	3.15	0.16 STT SUELLING
1564	6108 1	1.004 277	0.0012 326	35.6	35.6	44.9	9.18	576	1102	1102	0.0	45	0.0143	0.0073	0.0114	1.03	3.32	3.15	3.15	3.15	3.15	3.15	3.15	3.15	0.16 STT SUELLING
1565	24958	1.007 277	0.0011 324	36.4	36.4	27.6	5.14	462	886	886	0.0	42	0.0106	0.0106	0.0086	1.02	3.80	3.19	3.32	3.32	3.32	3.32	3.32	3.32	0.36 STT IDLE
1566	24958	1.007 277	0.0011 324	36.4	36.4	27.6	5.14	462	886	886	0.0	42	0.0106	0.0106	0.0086	1.02	3.80	3.19	3.32	3.32	3.32	3.32	3.32	3.32	0.36 STT IDLE
1567	14305	1.007 277	0.0012 326	33.9	33.9	27.6	5.14	462	886	886	0.0	42	0.0106	0.0106	0.0086	1.02	3.80	3.19	3.32	3.32	3.32	3.32	3.32	3.32	0.36 STT IDLE
1568	14305	1.007 277	0.0012 326	33.9	33.9	27.6	5.14	462	886	886	0.0	42	0.0106	0.0106	0.0086	1.02	3.80	3.19	3.32	3.32	3.32	3.32	3.32	3.32	0.36 STT IDLE
1569	1502 1	1.007 277	0.0012 326	28.2	28.2	21.2	3.74	437	823	823	0.0	40	0.0100												

53

## **APPENDIX C**

### **REFERENCES**

1. Roberts, A., Fiorentino, A., and Greene, W., "Experimental Clean Combustor Program," Phase III Final Report, NASA CR-135253, October 1977.

# APPENDIX D

## METRIC CONVERSION FACTORS

Approximate Conversions to Metric Measures				Approximate Conversions from Metric Measures			
Symbol	When You Know	Multiply by	To Find	Symbol	When You Know	Multiply by	To Find
<b>LENGTH</b>				<b>LENGTH</b>			
in	inches	2.5	centimeters	mm	millimeters	0.04	inches
ft	feet	30	centimeters	cm	centimeters	0.4	inches
yd	yards	0.9	meters	m	meters	3.3	feet
mi	miles	1.6	kilometers	km	kilometers	0.6	miles
<b>AREA</b>				<b>AREA</b>			
m <sup>2</sup>	square inches	6.5	square centimeters	cm <sup>2</sup>	square centimeters	0.16	square inches
ft <sup>2</sup>	square feet	0.09	square meters	m <sup>2</sup>	square meters	1.2	square yards
yd <sup>2</sup>	square yards	0.8	square meters	km <sup>2</sup>	square kilometers	0.4	square miles
mi <sup>2</sup>	square miles	2.6	square kilometers	ha	hectares (10,000 m <sup>2</sup> )	2.5	acres
<b>MASS (weight)</b>				<b>MASS (weight)</b>			
oz	ounces	28	grams	g	grams	0.035	ounces
lb	pounds	0.45	kilograms	kg	kilograms	2.2	pounds
	short tons	0.9	tonnes	t	tonnes (1000 kg)	1.1	short tons
<b>VOLUME</b>				<b>VOLUME</b>			
tsp	teaspoons	5	milliliters	ml	milliliters	0.03	fluid ounces
fl oz	fluid ounces	15	milliliters	l	liters	2.1	pints
c	cups	30	milliliters	l	liters	1.06	quarts
pt	pints	0.24	liters	m <sup>3</sup>	cubic meters	0.26	gallons
qt	quarts	0.47	liters	m <sup>3</sup>	cubic meters	35	cubic feet
gal	gallons	0.95	liters	m <sup>3</sup>	cubic meters	1.3	cubic yards
ft <sup>3</sup>	cubic feet	3.8	cubic meters				
yd <sup>3</sup>	cubic yards	0.03	cubic meters				
		0.76	cubic meters				
<b>TEMPERATURE (exact)</b>				<b>TEMPERATURE (exact)</b>			
°F	Fahrenheit temperature	5/9 (after subtracting 32)	Celsius temperature	°C	Celsius temperature	9/5 (then add 32)	Fahrenheit temperature

